

FORM PTO 1390  
(REV 5-98)

US DEPARTMENT OF COMMERCE PATENT AND TRADEMARK OFFICE


ATTORNEY DOCKET NUMBER  
2001\_0464ATRANSMITTAL LETTER TO THE UNITED STATES  
DESIGNATED/ELECTED OFFICE (DO/EO/US)  
CONCERNING A FILING UNDER 35 U.S.C. §371U.S. APPLICATION NO.  
(if known, see 37 CFR 1.01)  
NEW 09/831453International Application No.  
PCT/JP99/06313International Filing Date  
November 12, 1999Priority Date Claimed  
November 12, 1998Title of Invention  
METHOD AND APPARATUS FOR MOLDING BEADApplicant(s) For DO/EO/US  
Shinji OKUDA; Masaharu TAKADA; and Hitoshi FUJII

Applicant herewith submits to the United States Designated/Elected Office (DO/EO/US) the following items and other information:

1. ☒ This is a **FIRST** submission of items concerning a filing under 35 U.S.C. §371.
2. ☐ This is a **SECOND** or **SUBSEQUENT** submission of items concerning a filing under 35 U.S.C. §371.
3. ☒ This express request to begin national examination procedures (35 U.S.C. §371(f)) at any time rather than delay examination until the expiration of the applicable time limit set in 35 U.S.C. §371(b) and PCT Articles 22 and 39(1).
4. ☒ A proper Demand for International Preliminary Examination was made by the 19th month from the earliest claimed priority date.
5. ☒ A copy of the International Application as filed (35 U.S.C. §371(c)(2))
  - a. ☐ is transmitted herewith (required only if not transmitted by the International Bureau).
  - b. ☒ has been transmitted by the International Bureau. (Form PCT/IB/308) - **Attachment "A"**
  - c. ☐ is not required, as the application was filed in the United States Receiving Office (RO/US)
6. ☒ A translation of the International Application into English (35 U.S.C. §371(c)(2)). - **Attachment "B"**
7. ☐ Amendments to the claims of the International Application under PCT Article 19 (35 U.S.C. §371(c)(3)).
  - a. ☐ are transmitted herewith (required only if not transmitted by the International Bureau).
  - b. ☐ have been transmitted by the International Bureau.
  - c. ☐ have not been made; however, the time limit for making such amendments has NOT expired.
  - d. ☐ have not been made and will not be made.
8. ☐ A translation of the amendments to the claims under PCT Article 19.
9. ☒ An oath or declaration of the inventor(s) (35 U.S.C. §371(c)(4)). - **Attachment "C"**
10. ☐ A translation of the annexes to the International Preliminary Examination Report under PCT Article 36 (35 U.S.C. §371(c)(5)).

Items 11. to 14. below concern other document(s) or information included:

11. ☒ An Information Disclosure Statement under 37 CFR 1.97 and 1.98. - **Attachment "D"**
12. ☒ An assignment document for recording. A separate cover sheet in compliance with 37 CFR 3.28 and 3.31 is included. - **Attachment "E"**
13. ☒ A **FIRST** preliminary amendment. - **Attachment "F"**  
☐ A **SECOND** or **SUBSEQUENT** preliminary amendment.
14. ☒ Other items or information:  
 NOTIFICATION CONCERNING SUBMISSION OR TRANSMITTAL OF PRIORITY DOCUMENT - **Attachment "G"**

| U.S. APPLICATION NO. (if known, enter in (1.5))<br>NEW <b>09, 831453</b>   |              | INTERNATIONAL APPLICATION NO.<br>PCT/JP99/06313 |   | ATTORNEY'S DOCKET NO.<br>2001 0464A   |         |              |              |          |  |
|--|--------------|---|---|---|---------|--------------|--------------|----------|--|
| 15. [X] The following fees are submitted<br><br><b>BASIC NATIONAL FEE (37 CFR 1.492(a)(1)-(5)):</b><br>Neither international preliminary examination fee nor international search fee paid to USPTO<br>and International Search Report not prepared by the EPO or JPO ..... \$1000.00<br>International Search Report has been prepared by the EPO or JPO ..... \$ 860.00<br>International preliminary examination fee not paid to USPTO but international search<br>paid to USPTO ..... \$ 710.00<br>International preliminary examination fee paid to USPTO but claims did not satisfy provisions<br>of PCT Article 33(1)-(4) ..... \$ 690.00<br>International preliminary examination fee paid to USPTO and all claims satisfied provisions of<br>PCT Article 33(1)-(4) ..... \$ 100.00<br><br><b>ENTER APPROPRIATE BASIC FEE AMOUNT =</b> |              |   |   | <table border="1" style="width:100%; border-collapse: collapse;"> <tr> <th style="width:50%;">CALCULATIONS</th> <th style="width:50%;">PTO USE ONLY</th> </tr> <tr> <td style="height: 100px; vertical-align: bottom;">\$860.00</td> <td></td> </tr> </table> |         | CALCULATIONS | PTO USE ONLY | \$860.00 |  |
| CALCULATIONS   | PTO USE ONLY |   |   |   |         |              |              |          |  |
| \$860.00   |              |   |   |   |         |              |              |          |  |
| Surcharge of \$130.00 for furnishing the oath or declaration later than <input type="checkbox"/> 20 <input type="checkbox"/> 30 months from the earliest<br>claimed priority date (37 CFR 1.492(e)).   |              |   |   | <table border="1" style="width:100%; border-collapse: collapse;"> <tr> <td style="width:50%;">\$</td> <td style="width:50%;"></td> </tr> </table>   |         | \$           |              |          |  |
| \$   |              |   |   |   |         |              |              |          |  |
| Claims   | Number Filed | Number Extra                                    | Rate  |   |         |              |              |          |  |
| Total Claims   | 61 -20 =     | 41  | X \$18.00   | \$738.00  |         |              |              |          |  |
| Independent Claims   | 10 - 3 =     | 7   | X \$80.00   | \$560.00  |         |              |              |          |  |
| Multiple dependent claim(s) (if applicable)  |              |   | + \$270.00  | \$  |         |              |              |          |  |
| <b>TOTAL OF ABOVE CALCULATIONS =</b>   |              |   |   | \$2,158.00  |         |              |              |          |  |
| <input type="checkbox"/> Small Entity Status is hereby asserted. Above fees are reduced by 1/2.  |              |   |   | \$  |         |              |              |          |  |
| <b>SUBTOTAL =</b>  |              |   |   | \$2,158.00  |         |              |              |          |  |
| Processing fee of \$130.00 for furnishing the English translation later than <input type="checkbox"/> 20 <input type="checkbox"/> 30 months from the earliest<br>claimed priority date (37 CFR 1.492(f)).  |              |   |   | +   | \$      |              |              |          |  |
| <b>TOTAL NATIONAL FEE =</b>  |              |   |   | \$2,158.00  |         |              |              |          |  |
| Fee for recording the enclosed assignment (37 CFR 1.21(h)). The assignment must be accompanied by an<br>appropriate cover sheet (37 CFR 3.28, 3.31). \$40 per property   |              |   |   | +   | \$40.00 |              |              |          |  |
| <b>TOTAL FEES ENCLOSED =</b>   |              |   |   | \$2,198.00  |         |              |              |          |  |
|  |              |   |   | Amount to be refunded   | \$      |              |              |          |  |
|  |              |   |   | Amount to be charged  | \$      |              |              |          |  |
| a. [X] A check in the amount of <u>\$2,198.00</u> to cover the above fees is enclosed. A duplicate copy of this form is enclosed.<br>b. <input type="checkbox"/> Please charge my Deposit Account No. 23-0975 in the amount of \$ _____ to cover the above fees.<br>A duplicate copy of this sheet is enclosed.<br>c. <input type="checkbox"/> The Commissioner is hereby authorized to charge any additional fees which may be required, or credit any<br>overpayment to Deposit Account No. <u>23-0975</u> .   |              |   |   |   |         |              |              |          |  |
| <b>NOTE: Where an appropriate time limit under 37 CFR 1.494 or 1.495 has not been met, a petition to revive (37 CFR 1.137(a) or (b)) must be filed and granted to restore the application to pending status.</b>   |              |   |   |   |         |              |              |          |  |
| 19. CORRESPONDENCE ADDRESS<br><br><div style="text-align: center;"> <br/> <b>000513</b><br/>         PATENT TRADEMARK OFFICE       </div>   |              |   | By: <u>Michael S. Huppert</u><br>Michael S. Huppert,<br>Registration No. 40,268<br><br>WENDEROTH, LIND & PONACK, L.L.P.<br>2033 "K" Street, N.W., Suite 800<br>Washington, D.C. 20006-1021<br>Phone: (202) 721-8200<br>Fax: (202) 721-8250<br><br><div style="text-align: right;">May 9, 2001</div> |   |         |              |              |          |  |

[CHECK NO. 44318]

[2001\_0464A]

09/831453

JC08 Rec'd PCT/PTO 09 MAY 2001

IN THE UNITED STATES PATENT AND TRADEMARK OFFICE

In re application of :  
Shinji OKUDA et al. : Attn: BOX PCT  
Serial No. NEW : Docket No. 2001\_0464A  
Filed May 9, 2001 :

METHOD AND APPARATUS FOR MOLDING BEAD  
[Corresponding to PCT/JP99/06313  
Filed November 12, 1999]

THE COMMISSIONER IS AUTHORIZED  
TO CHARGE ANY DEFICIENCY IN THE  
FEE FOR THIS PAPER TO DEPOSIT  
ACCOUNT NO. 23-0975.

PRELIMINARY AMENDMENT

Assistant Commissioner for Patents,  
Washington, DC 20231

Sir:

Prior to initial examination for the above-identified new PCT  
application, kindly amend the application as follows:

IN THE CLAIMS:

Kindly amend claims 3, 5-6, 10-12, 14-15, 22-24, 33, 37, and  
39 as follows:

3. (Amended) The bead molding method as claimed in claim 1,  
wherein the bead molding step molds the hollow bead into a shapes  
corresponding to and following the shape of the applying position  
by applying the work with the hollow bead or the foamable material  
onto the applying position while transferring the streams along the  
applying position.

Attachment "F"

5. (Amended) The bead molding method as claimed in claim 1, further comprising a discharging device including an inner nozzle elongated at a tip portion thereof and an outer nozzle elongated about and enclosing an outer periphery of the inner nozzle; wherein:

the gas stream forming step forms the gas stream in the one direction by discharging gases from the inner nozzle; and

the material stream forming step forms the highly viscous material stream or the foamable material stream in the same direction of the gas stream about and enclosing the gas stream by discharging the highly viscous material or the foamable material from the outer nozzle.

6. (Amended) The bead molding method as claimed in claim 3, wherein there is disposed a discharging device including an inner nozzle elongated at a tip portion thereof and an outer nozzle elongated about and enclosing an outer periphery of the inner nozzle;

the gas stream forming step forms the gas stream in the one direction by discharging the gases from the inner nozzle;

the material stream forming step forms a stream of the highly viscous material or the foamable material in the same direction of the gas stream about and enclosing the gas stream by



discharging the highly viscous material or the foamable material from the outer nozzle; and

the bead molding step molds a hollow bead into a shape corresponding to and following the shape of the applying position by discharging the highly viscous material stream or the foamable material stream toward the work from the inner nozzle and the outer nozzle in the outer peripheral space of the gas stream while transferring the nozzles in a locus corresponding to and following the shape of the applying position.

10. (Amended) The bead molding method as claimed in claim 7, wherein:

there is disposed a discharging device including an inner nozzle elongated at its tip and an outer nozzle elongated about and enclosing an outer periphery of the inner nozzle;

the foamable material stream forming step forms the foamable material stream in the one direction by discharging the foamable material stream from the inner nozzle; and

the material stream forming step forms the highly viscous material stream in the same direction of the foamable material stream and about and enclosing the foamable material stream by discharging the highly viscous material stream from the outer nozzle.

11. (Amended) The bead molding method as claimed in claim 8, wherein:

there is disposed a discharging device including an inner nozzle elongated at its tip and an outer nozzle elongated about and enclosing an outer periphery of the inner nozzle;

the foamable material stream forming step forms the foamable material stream in the one direction by discharging the foamable material stream from the inner nozzle;

the material stream forming step forms the highly viscous material stream in the same direction of the foamable material stream by discharging the highly viscous material stream from the outer nozzle; and

the bead molding step molds the foamed bead in a given shape following the shape of the applying position while transferring the inner nozzle and the outer nozzle along a predetermined locus following the work by discharging the foamable material stream and the highly viscous material stream onto the applying position from the inner nozzle and the outer nozzle, respectively.

12. (Amended) The bead molding method as claimed in claim 6, wherein:

the discharging device is mounted on a manipulator disposed to be transferable to a desired position in response to a control signal; and

the bead molding step for applying and molding the hollow bead or the foamed bead automatically on the applying position of a plurality of work members being carried one after another on a manufacturing line by controlling a movement of the discharging device by means of the manipulator.

14. (Amended) The bead molding method as claimed in claim 12, wherein it is decided to automatically determine whether the bead is applied and molded in a favorable fashion by desired picking up an image of the bead applied and molded on the applying position and comparing the picked-up image of the bead with a reference image of a bead applied and molded in a predetermined favorable fashion.

15. (Amended) The bead molding method as claimed in claim 12, wherein the work member comprises an opening and closing member for closing a predetermined opening thereof.

22. (Amended) The bead molding apparatus as claimed in claim 17, wherein the discharging device is arranged so as for each of the inner nozzle and the outer nozzle to change an inner dimension of its inner wall into a smaller size over a region extending from an end portion of connection with a body of the discharging device to a tip portion thereof having a defined inner dimension.

23. (Amended) The bead molding apparatus as claimed in claim 17, wherein an outer wall portion of each of the inner nozzle and the outer nozzle containing an edge section at the top thereof has an inclining surface joining at an acute angle to the direction of the flow of the highly viscous material stream or the foamable material stream.

24. (Amended) The bead molding apparatus as claimed in claim 17, wherein the inner nozzle and the outer nozzle are provided, respectively, with a first control valve for controlling the opening and closing of a path reaching the inner nozzle from the first inlet and a second control valve for controlling the opening and closing of a path reaching the outer nozzle from the second inlet.

33. (Amended) The bead molding method as claimed in claim 31, wherein the bead molding step molds the hollow bead into a shape

corresponding to and following the shape of a applying position by transferring the hot melt material stream or the foamable hot melt material stream along the applying position while applying the work with the hot melt material or the foamable hot melt material.

37. (Amended) The bead molding method as claimed in claim 35, wherein:

there is disposed a discharging device including an inner nozzle elongated at a tip portion thereof and an outer nozzle elongated enclosing an outer periphery of the inner nozzle;

the foamable material stream forming step forms the foamable hot melt material stream in the one direction by discharging the foamable hot melt material from the inner nozzle; and

the material stream forming step forms the hot melt material stream in the direction equal to the direction of the foamable hot melt material stream and enclosing the foamable hot melt material by discharging the hot melt material from the outer nozzle.

39. (Amended) The bead molding method as claimed in claim 37, wherein:

the discharging device is mounted on a manipulator disposed to be movable to a desired position in response to a control signal; and

the bead molding step applies and molds the hollow bead or the foamed bead automatically on the applying position of a plurality of work members being carried on a manufacturing line one after another by controlling the movement of the discharging device by means of the manipulator.

**Kindly add the following new claims:**

43.(NEW) The bead molding method as claimed in claim 2, wherein the bead molding step molds the hollow bead into a shapes corresponding to and following the shape of the applying position by applying the work with the hollow bead or the foamable material onto the applying position while transferring the streams along the applying position.

44.(NEW) The bead molding method as claimed in claim 43, wherein the hollow bead applied and molded are tackied or adhesived to the work by using the highly viscous material or the formable material has an tackinessly or adhesive property.

45.(NEW) The bead molding method as claimed in claim 2, further comprising a discharging device including an inner nozzle

elongated at a tip portion thereof and an outer nozzle elongated about and enclosing an outer periphery of the inner nozzle; wherein:

the gas stream forming step forms the gas stream in the one direction by discharging gases from the inner nozzle; and

the material stream forming step forms the highly viscous material stream or the foamable material stream in the same direction of the gas stream about and enclosing the gas stream by discharging the highly viscous material or the foamable material from the outer nozzle.

46.(NEW) The bead molding method as claimed in claim 11, wherein:

the discharging device is mounted on a manipulator disposed to be transferable to a desired position in response to a control signal; and

the bead molding step for applying and molding the hollow bead or the foamed bead automatically on the applying position of a plurality of work members being carried one after another on a manufacturing line by controlling a movement of the discharging device by means of the manipulator.

47.(NEW) The bead molding method as claimed in claim 46, wherein actual applying position of the bead applied by the

discharging device is detected and the manipulator is controlled so as to substantially bring the actual applying position thereof into agreement with a predetermined target applying position.

48.(NEW) The bead molding method as claimed in claim 46, wherein it is decided to automatically determine whether the bead is applied and molded in a favorable fashion by desired picking up an image of the bead applied and molded on the applying position and comparing the picked-up image of the bead with a reference image of a bead applied and molded in a predetermined favorable fashion.

49.(NEW) The bead molding method as claimed in claim 46, wherein the work member comprises an opening and closing member for closing a predetermined opening thereof.

50.(NEW) The bead molding method as claimed in claim 49, wherein the applying position comprises a site disposed along and nearby an edge portion of the opening and closing member, and the hollow bead or the foamed bead applied and molded on the applying position forms a sealing section that seals a gap between the opening and the opening and closing member.



51.(NEW) The bead molding apparatus as claimed in claim 18, wherein the discharging device is arranged so as for each of the inner nozzle and the outer nozzle to change an inner dimension of its inner wall into a smaller size over a region extending from an end portion of connection with a body of the discharging device to a tip portion thereof having a defined inner dimension.

52.(NEW) The bead molding apparatus as claimed in claim 18, wherein an outer wall portion of each of the inner nozzle and the outer nozzle containing an edge section at the top thereof has an inclining surface joining at an acute angle to the direction of the flow of the highly viscous material stream or the foamable material stream.

53.(NEW) The bead molding apparatus as claimed in claim 18, wherein the inner nozzle and the outer nozzle are provided, respectively, with a first control valve for controlling the opening and closing of a path reaching the inner nozzle from the first inlet and a second control valve for controlling the opening and closing of a path reaching the outer nozzle from the second inlet.

54.(NEW) The bead molding apparatus as claimed in claim 53, wherein the discharging device is capable of being hand-carried;

and each of the first control valve and the second control valve is capable of being opened and closed by a manual on-off operation.

55.(NEW) The bead molding apparatus as claimed in claim 53, wherein each of the first control valve and the second control valve is capable of being opened and closed automatically in response to an control signal.

56.(NEW) The bead molding apparatus as claimed in claim 55, further comprising:

a manipulator mounted on the discharging device at a top portion thereof and disposed so as to be movable to a desired position in response to a control signal; and

a control unit for automatically controlling the movement of the manipulator and the discharging of the discharging device in accordance with a predetermined program.

57.(NEW) The bead molding apparatus as claimed in claim 56, wherein the control unit automatically controls the movement of the manipulator and the discharge of the discharging device so as to automatically apply and mold the hollow bead or the foamed bead on a applying position of each of a plurality of work being carried on a manufacturing line one after another.

58.(NEW) The bead molding apparatus as claimed in claim 57, further comprising a detection unit for detecting an actual applying position of work the bead by the discharging device;

wherein the control unit controls the manipulator so as to bring the actual applying position detected thereby substantially into agreement with a predetermined target applying position of work.

59.(NEW) The bead molding apparatus as claimed in claim 58, further comprising an image pick-up unit for picking up an image of the bead applied and molded on the applying position,

wherein the control unit automatically decides to determine whether the bead is applied and applied thereon in a favorable fashion by comparing the image of the bead picked-up by the image pick-up unit with a pre-stored reference image of the bead applied and molded in a favorable fashion.

60.(NEW) The bead molding method as claimed in claim 32, wherein the bead molding step molds the hollow bead into a shape corresponding to and following the shape of a applying position by transferring the hot melt material stream or the foamable hot melt material stream along the applying position while applying the work with the hot melt material or the foamable hot melt material.

61.(NEW) The bead molding method as claimed in claim 60, wherein:

there is disposed a discharging device including an inner nozzle elongated at a tip portion thereof and an outer nozzle elongated about and enclosing an outer periphery of the inner nozzle;

the gases stream forming step forms the gas stream in a one direction by discharging gases from the inner nozzle;

the material stream forming step forms the hot melt material stream or the foamable hot melt material stream in the same direction as the gas stream by discharging the hot melt material or the foamable hot melt material from the outer nozzle; and

the bead molding step forms the hollow bead into the shape corresponding to and following the shape of the applying position by transferring the hot melt material stream or the foamable hot melt material stream along a predetermined locus while discharging the gas stream from the inner nozzle and the material stream from the outer nozzle toward the work.

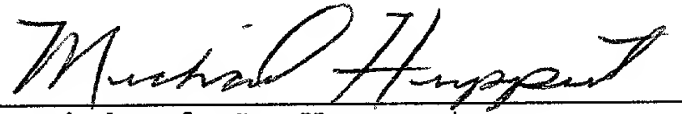
## REMARKS

The present Preliminary Amendment is submitted to delete the multiple dependencies of claims 3, 5-6, 10-12, 14-15, 22-24, 33, 37, and 39 thereby placing such claims in condition for examination and reducing the required PTO filing fee.

Copies of the amended portion of the claims with changes marked therein is attached and entitled "*Version with Markings to Show Changes Made.*"

Respectfully submitted,

Shinji OKUDA et al.

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May 9, 2001

CLAIMS

1. A bead molding method for molding a hollow bead from a highly viscous material that is fluid in the form of a stream in a high speed flow region and can retain a shape into which it is molded in a low speed flow region; comprising:

a gas stream forming step for forming a gas stream in a one direction;

a material stream forming step for forming a highly viscous material stream flowing in the high speed flow region within an outer peripheral space about and enclosing the gas stream; and

a bead molding step for molding the hollow bead into an irregular shape by reducing the flow speed of the highly viscous material stream from the high speed flow to the low speed flow while rendering the highly viscous material stream fluid within the outer peripheral space about and enclosing the gas stream.

2. A bead molding method for molding a hollow bead from a foamable material for forming a foamed body, comprising:

a gas stream forming step for forming a gas stream in a one direction;

a material stream forming step for forming a foamable material stream flowing in the same direction as the gas stream within an outer peripheral space about and enclosing the gas stream; and

a bead molding step for molding the hollow bead into an irregular shape by reducing the flow speed of the

foamable material stream from the high speed flow to the low speed flow while fluidizing the foamable material stream flowing within the outer peripheral space about and enclosing the gas stream.

3. The bead molding method as claimed in claim 1 or 2, wherein the bead molding step molds the hollow bead into a shapes corresponding to and following the shape of the applying position by applying the work with the hollow bead or the foamable material onto the applying position while transferring the streams along the applying position.

4. The bead molding method as claimed in claim 3, wherein the hollow bead applied and molded are tackied or adhesived to the work by using the highly viscous material or the foamable material has an tackinessly or adhesive property.

5. The bead molding method as claimed in ~~any one of~~ claims 1 to 4, further comprising a discharging device including an inner nozzle elongated at a tip portion thereof and an outer nozzle elongated about and enclosing an outer periphery of the inner nozzle; wherein:

the gas stream forming step forms the gas stream in the one direction by discharging gases from the inner nozzle; and

the material stream forming step forms the highly viscous material stream or the foamable material stream in the same direction of the gas stream about and enclosing the gas stream by discharging the highly viscous material or the foamable material from the outer nozzle.

6. The bead molding method as claimed in claim 3 [or 4] wherein there is disposed a discharging device including an inner nozzle elongated at a tip portion thereof and an outer nozzle elongated about and enclosing an outer periphery of the inner nozzle;

the gas stream forming step forms the gas stream in the one direction by discharging the gases from the inner nozzle;

the material stream forming step forms a stream of the highly viscous material or the foamable material in the same direction of the gas stream about and enclosing the gas stream by discharging the highly viscous material or the foamable material from the outer nozzle; and

the bead molding step molds a hollow bead into a shape corresponding to and following the shape of the applying position by discharging the highly viscous material stream or the foamable material stream toward the work from the inner nozzle and the outer nozzle in the outer peripheral space of the gas stream while transferring the nozzles in a locus corresponding to and following the shape of the applying position.

7. A bead molding method for molding a foamed bead into a given shape, composed of a foamed body covered with a highly viscous material that is fluid in the form of a stream in a high speed flow region and retains the shape into which it is molded in a low speed flow region, comprising:

a foamable material stream forming step for forming a



stream of a foamable material for forming the foamed body in a one direction;

a material stream forming step for forming a stream of the highly viscous material in the high speed flow region in an outer peripheral space enclosing and about the foamable material stream; and

a foamed bead molding step for molding the foamed bead into an irregular shape by foaming the foamable material while fluidizing the highly viscous material flowing in the outer peripheral space of the foamable material stream and reducing the high speed flow of the foamable material stream to the low speed flow thereof.

8. The bead molding method as claimed in claim 7, wherein the foamed bead molding step molds the foamed bead into the given shape by following the shape of the applying position while transferring the foamable material stream and the highly viscous material stream along the shape of the applying position while applying the work with the foamable material and the highly viscous material.

9. The bead molding method as claimed in claim 8, wherein the highly viscous material has an tackiness or adhesive property and the foamed bead applied and molded are tackied or adhesived to the work.

10. The bead molding method as claimed in ~~any one of~~ claims 7 [to 9] wherein:

there is disposed a discharging device including an inner nozzle elongated at its tip and an outer nozzle elongated about and enclosing an outer periphery of the

inner nozzle;

the foamable material stream forming step forms the foamable material stream in the one direction by discharging the foamable material stream from the inner nozzle; and

the material stream forming step forms the highly viscous material stream in the same direction of the foamable material stream and about and enclosing the foamable material stream by discharging the highly viscous material stream from the outer nozzle.

11. The bead molding method as claimed in claim 8 [or 9], wherein:

there is disposed a discharging device including an inner nozzle elongated at its tip and an outer nozzle elongated about and enclosing an outer periphery of the inner nozzle;

the foamable material stream forming step forms the foamable material stream in the one direction by discharging the foamable material stream from the inner nozzle;

the material stream forming step forms the highly viscous material stream in the same direction of the foamable material stream by discharging the highly viscous material stream from the outer nozzle; and

the bead molding step molds the foamed bead in a given shape following the shape of the applying position while transferring the inner nozzle and the outer nozzle along a predetermined locus following the work by

discharging the foamable material stream and the highly viscous material stream onto the applying position from the inner nozzle and the outer nozzle, respectively.

12. The bead molding method as claimed in claim 6 [or 11], wherein:

the discharging device is mounted on a manipulator disposed to be transferable to a desired position in response to a control signal; and

the bead molding step for applying and molding the hollow bead or the foamed bead automatically on the applying position of a plurality of work members being carried one after another on a manufacturing line by controlling a movement of the discharging device by means of the manipulator.

13. The bead molding method as claimed in claim 12, wherein an actual applying position of the bead applied by the discharging device is detected and the manipulator is controlled so as to substantially bring the actual applying position thereof into agreement with a predetermined target applying position.

14. The bead molding method as claimed in claim 12 [or 13], wherein it is decided to automatically determine whether the bead is applied and molded in a favorable fashion by desired picking up an image of the bead applied and molded on the applying position and comparing the picked-up image of the bead with a reference image of a bead applied and molded in a predetermined favorable fashion.

15. The bead molding method as claimed in ~~any one of~~

claims 12 [to 14], wherein the work member comprises an opening and closing member for closing a predetermined opening thereof.

16. The bead molding method as claimed in claim 15, wherein the applying position comprises a site disposed along and nearby an edge portion of the opening and closing member, and the hollow bead or the foamed bead applied and molded on the applying position forms a sealing section that seals a gap between the opening and the opening and closing member.

17. A bead molding apparatus for molding a hollow bead comprising:

a discharging device including an inner nozzle disposed extending at a tip portion, an outer nozzle disposed extending about and enclosing an outer periphery of the inner nozzle, a first inlet connecting with the inner nozzle, and a second inlet connecting with the outer nozzle;

a gases feed unit for feeding gases to the discharging device through the first inlet; and

a material feed unit for feeding a highly viscous material or a foamable material to the discharging device through the second inlet, the highly viscous material being fluid in the form of a stream in a high speed flow region and capable of retaining a shape into which it is molded in a low speed flow region.

18. A bead molding apparatus for molding foamed bead comprising:

a discharging device including an inner nozzle disposed extending at a tip portion, an outer nozzle disposed extending about and enclosing an outer periphery of the inner nozzle, a first inlet connecting with the inner nozzle, and a second inlet connecting with the outer nozzle;

a foamable material feed unit for feeding a foamable material to the discharging device through the first inlet; and

a material feed unit for feeding a highly viscous material to the discharging device through the second inlet, the highly viscous material being fluid in the form of a stream in a high speed flow region and capable of retaining a shape into which it is molded in a low speed flow region.

19. The bead molding apparatus as claimed in claim 18, wherein the foamable material feed unit feeds a mixture of the gases with the highly viscous material as the foamable material.

20. The bead molding apparatus as claimed in claim 19, wherein the foamable material feed unit comprises:

a plurality of piston pumps arranged so as to perform an suction stroke and a extrusion stroke by reciprocally moving a piston in a cylinder;

a gases injection unit for supplying gases under a predetermined pressure into the cylinder; and

a formable material supplying unit for a pump control unit for controlling the plurality of the piston pumps in such a manner that each of the plurality of the piston

pumps is arranged to conduct the suction stroke for feeding gases and with the highly viscous material after the suction stroke and to conduct the extrusion stroke for discharging the mixture of the gases with the highly viscous material as the foamable material as well as that a time difference is provided for the extrusion stroke of each of the plurality of the piston pumps so as to continually discharge a predetermined quantity of the foamable material.

21. The bead molding apparatus as claimed in claim 20, wherein the foamable material feed unit further comprises a tubular path for dispersing minute bubbles of gases disposed in a discharge path of each piston pump.

22. The bead molding apparatus as claimed in ~~any one of~~ claims 17 [to 21], wherein the discharging device is arranged so as for each of the inner nozzle and the outer nozzle to change an inner dimension of its inner wall into a smaller size over a region extending from an end portion of connection with a body of the discharging device to a tip portion thereof having a defined inner dimension.

23. The bead molding apparatus as claimed in ~~any one of~~ claims 17 [to 22], wherein an outer wall portion of each of the inner nozzle and the outer nozzle containing an edge section at the top thereof has an inclining surface joining at an acute angle to the direction of the flow of the highly viscous material stream or the foamable material stream.

24. The bead molding apparatus as claimed in ~~any one of~~

claims 17 [to 23], wherein the inner nozzle and the outer nozzle are provided, respectively, with a first control valve for controlling the opening and closing of a path reaching the inner nozzle from the first inlet and a second control valve for controlling the opening and closing of a path reaching the outer nozzle from the second inlet.

25. The bead molding apparatus as claimed in claim 24, wherein the discharging device is capable of being hand-carried; and each of the first control valve and the second control valve is capable of being opened and closed by a manual on-off operation.

26. The bead molding apparatus as claimed in claim 24, wherein each of the first control valve and the second control valve is capable of being opened and closed automatically in response to an control signal.

27. The bead molding apparatus as claimed in claim 26, further comprising:

a manipulator mounted on the discharging device at a top portion thereof and disposed so as to be movable to a desired position in response to a control signal; and

a control unit for automatically controlling the movement of the manipulator and the discharging of the discharging device in accordance with a predetermined program.

28. The bead molding apparatus as claimed in claim 27, wherein the control unit automatically controls the movement of the manipulator and the discharge of the discharging device so as to automatically apply and mold

the hollow bead or the foamed bead on a applying position of each of a plurality of work being carried on a manufacturing line one after another.

29. The bead molding apparatus as claimed in claim 28, further comprising a detection unit for detecting an actual applying position of work the bead by the discharging device;

wherein the control unit controls the manipulator so as to bring the actual applying position detected thereby substantially into agreement with a predetermined target applying position of work.

30. The bead molding apparatus as claimed in claim 29, further comprising an image pick-up unit for picking up an image of the bead applied and molded on the applying position,

wherein the control unit automatically decides to determine whether the bead is applied and applied thereon in a favorable fashion by comparing the image of the bead picked-up by the image pick-up unit with a pre-stored reference image of the bead applied and molded in a favorable fashion.

31. A bead molding method for molding a hollow bead from a hot melt material that is fluid in the form of a stream in a middle-high temperature region and can retain a shape into which the hollow bead are molded in a middle-low temperature region;

a gas stream forming step for forming a gas stream flowing in a one direction;



a material stream forming step for forming a hot melt material stream in the middle-high temperature region within an outer peripheral space about and outside so as to enclose the gas stream; and

a bead molding step for molding the hollow bead into an irregular shape by lowering the middle-high temperature of the hot melt material to the middle-low temperature while fluidizing the hot melt material flowing in the outer peripheral space about the gas stream.

32. A bead molding method for molding a hollow bead from a foamable hot melt material for forming a foamed body, comprising:

a gases stream forming step for forming a gas stream in a one direction;

a material stream forming step for forming a stream of the foamable hot melt material in the direction identical to the direction of the gas stream within an outer peripheral space about and enclosing the flow of the gas stream; and

a bead molding step for molding the hollow bead into an irregular shape by foaming the foamable hot melt material flowing within the outer peripheral space of the gas stream.

33. The bead molding method as claimed in claim 31 [or 32], wherein the bead molding step molds the hollow bead into a shape corresponding to and following the shape of a applying position by transferring the hot melt material stream or the foamable hot melt material stream along the

applying position while applying the work with the hot melt material or the foamable hot melt material.

34. The bead molding method as claimed in claim 33, wherein:

there is disposed a discharging device including an inner nozzle elongated at a tip portion thereof and an outer nozzle elongated about and enclosing an outer periphery of the inner nozzle;

the gases stream forming step forms the gas stream in a one direction by discharging gases from the inner nozzle;

the material stream forming step forms the hot melt material stream or the foamable hot melt material stream in the same direction as the gas stream by discharging the hot melt material or the foamable hot melt material from the outer nozzle; and

the bead molding step forms the hollow bead into the shape corresponding to and following the shape of the applying position by transferring the hot melt material stream or the foamable hot melt material stream along a predetermined locus while discharging the gas stream from the inner nozzle and the material stream from the outer nozzle toward the work.

35. A bead molding method for molding a foamed bead comprised of a foamed body covered with a hot melt material that is fluid in the form of a stream in a middle-high temperature region and can retain the shape into which it is molded in a middle-low temperature region; comprising:

a foamable stream forming step for forming a stream

of a foamable hot melt material for forming the foamed body;

a material stream forming step for forming a stream of the hot melt material flowing in the middle-high temperature region within an outer peripheral space the foamable hot melt material stream about and enclosing the foamable hot melt material stream; and

a bead-molding step for molding the foamed bead into an irregular shape by reducing the middle-high temperature region to the middle-low temperature region while fluidizing the hot melt material stream flowing within the outer peripheral side outside and about the foamable hot melt material stream.

36. The bead molding method as claimed in claim 35, wherein the bead-molding step molds the foamed bead into a shape corresponding to and following the shape of the applying position by transferring the foamable hot melt material stream and the hot melt material stream along the applying position while applying the work with the foamable hot melt material and the hot melt material.

37. The bead molding method as claimed in claim 35 [or 36], wherein:

there is disposed a discharging device including an inner nozzle elongated at a tip portion thereof and an outer nozzle elongated enclosing an outer periphery of the inner nozzle;

the foamable material stream forming step forms the foamable hot melt material stream in the one direction by

discharging the foamable hot melt material from the inner nozzle; and

the material stream forming step forms the hot melt material stream in the direction equal to the direction of the foamable hot melt material stream and enclosing the foamable hot melt material by discharging the hot melt material from the outer nozzle.

38. The bead molding method as claimed in claim 36, wherein:

there is disposed a discharging device including an inner nozzle elongated at a tip portion thereof and an outer nozzle elongated enclosing an outer periphery of the inner nozzle;

the foamable material stream forming step forms the foamable hot melt material stream in the one direction by discharging the foamable hot melt material from the inner nozzle;

the material stream forming step forms the hot melt material stream in the same direction as the direction of the foamable hot melt material stream and enclosing the formable not melt material by discharging the hot melt material from the outer nozzle; and

the bead molding step for molding a foamed bead into a shape corresponding to and following the shape of the applying position by transferring the material stream along a given position while discharging the foamable hot melt material and the hot melt material from the inner nozzle and the outer nozzle, respectively.

39. The bead molding method as claimed in claim 37[or 38], wherein:

the discharging device is mounted on a manipulator disposed to be movable to a desired position in response to a control signal; and

the bead molding step applies and molds the hollow bead or the foamed bead automatically on the applying position of a plurality of work members being carried on a manufacturing line one after another by controlling the movement of the discharging device by means of the manipulator.

40. A bead forming apparatus for forming a hollow bead comprising:

a discharging device including an inner nozzle elongated at a tip portion thereof, an outer nozzle elongated about and enclosing an outer periphery of the inner nozzle, a first inlet connecting with the inner nozzle, and a second inlet connecting with the outer nozzle;

a gases feed unit for feeding gases to the discharging device through the first inlet; and

a material feed unit for feeding a hot melt material or a foamable hot melt material to the discharging device through the second inlet, the hot melt material being fluid in the form of a stream in a middle-high temperature region and can retain the shape into which the material is molded in a middle-low temperature region.

41. A bead forming apparatus for forming a foamed bead

comprising:

a discharging device including an inner nozzle elongated at a tip portion thereof, an outer nozzle elongated about and enclosing an outer periphery of the inner nozzle, a first inlet connecting with the inner nozzle, and a second inlet connecting with the outer nozzle;

a first material feed unit for feeding a foamable hot melt material to the discharging device through the first inlet; and

a second material feed unit for feeding a hot melt material to the discharging device through the second inlet, the hot melt material being fluid in the form of a stream in a middle-high temperature region and can retain the shape into which the material is molded in a middle-low temperature region.

42. The bead molding apparatus as claimed in claim 41, wherein the first material feed unit feeds a mixture of the gases with the hot melt material as the foamable hot melt material.

## SPECIFICATION

## METHOD AND APPARATUS FOR MOLDING BEAD

## 1. Field of the Invention

The present invention relates to a method and an  
5 apparatus for molding a bead. More particularly, the  
present invention relates to a method for molding the  
hollow bead into an irregular shape from a highly viscous  
material or a foamable material and a method for molding  
the foamed bead covered with a highly viscous material into  
10 an irregular shape as well as to an apparatus for molding  
such a hollow bead and foamed bead.

## 2. Description of the Related Art

Japanese Patent Application Laid-open No. 3-178,362  
discloses a method and an apparatus for applying and  
15 molding a highly viscous material into foamed hollow bead  
(each having a hollow foamed portion raised in a linear  
fashion) or foamed bead with their sections being  
expandable.

The applying and molding apparatus disclosed in this  
20 prior patent application uses a mixer of a low energy  
consumption type for reducing heat generation and includes  
a mixing device that mixes feed gases in a pressurized  
state into the highly viscous material and feeds a foamable  
material with the highly viscous material dispersed in  
25 minute particles. The applying and molding apparatus  
further includes a discharging device that foams the  
foamable material fed from the mixing device by discharging  
it onto a work surface and forms a hollow bead in a tubular

shape. As shown in Fig. 13, the discharging device includes a nozzle for discharging the foamable material comprised of a mixture of the highly viscous material with the pressurized gases and a plunger disposed so as to be  
5 slidable in a direction (as indicated by symbol P) along an inner hole of the nozzle by means of a compression air piston (not shown).

Further, the inner hole of the nozzle of the applying device has a channel and a tapered wall section, the  
10 channel being disposed for carrying the foamable material fed to the nozzle to an orifice located at a tip section of the nozzle and the tapered wall section forming an inner wall portion extending from the end of the channel to the orifice thereof. On the other hand, the plunger includes a  
15 head portion in the form of an inverse truncated cone and a sectionally circular tip portion, the bottom portion being disposed so as to block the nozzle by close abutment with the tapered wall section and the sectionally circular tip portion being formed by cutting off the conical top section  
20 thereof while remaining a small portion with the cut top rendered flat.

As the plunger is located in the position as indicated in Fig. 13 and the nozzle is open, the foamable material fed to the nozzle from the mixing device travels  
25 through the channel in the direction as indicated by symbol Q in the drawing. The foamable material flows along the side surface of the truncated-conical head portion of the plunger in a pressurized state up to the circular tip



portion thereof. Once the foamable material reaches the circular tip portion of the plunger, the pressure of the foamable material is caused to drop rapidly through the channel because no plunger exists in the channel ahead of the circular tip portion and the sectional path area of the channel increases rapidly. Therefore, the rapid drop of the pressure of the foamable material causes a central area of the channel immediately under the circular tip portion, as shown in the drawing, to an area where the pressure drops. Within the pressure drop area of the channel, the foamable material is allowed to be formed into small masses as gaseous cores, where the gases mixed with the foamable material have been released outside from the mixture or brought into a state where they are likely to be released outside therefrom.

The remaining and surrounding portion of the foamable material, where no such gaseous cores are formed, foams into gaskets upon the discharge from the orifice and the rapid reduction in pressure of the foamable material up to atmospheric pressure. As the foamable material is being fed and the foaming is being carried out continually, the highly viscous polymer material forms an extruded bead in a tubular shape. On the other hand, the gaseous cores of the foamable material formed in the pressure drop area of the channel are allowed to foam at an early stage, for example, even during the course of the foamable material travelling through the nozzle, while being flown along the axis of the tubular bead. The gaseous cores in the central portion of

the tubular bead are allowed to foam earlier than the mixture at the surrounding portion, so that the central portion of the tubular bead is formed into a hollow bead in tubular shape, while the mixture at the surrounding portion  
5 foams.

The hollow tubular bead can completely seal, for example, a gap between an aperture and an opening/closing member by applying the contact portion thereof with them to block the gap. Further, the hollow tubular bead can  
10 provide the various advantages that the hollow structure of the tubular bead can increase the strength of the tubular bead itself and reduce the compressive stress upon closure of the aperture with the opening/closing member.

The prior art technology disclosed in the published  
15 patent application, however, has the defect that it requires complicated and large equipment for the preparation of a mixture of a highly viscous material with gases.

Furthermore, the prior art technology has the  
20 structure that a flow of the gaseous cores formed in the pressure drop area of the channel are likely to be influenced largely by the flow characteristics of the foamable material. Therefore, it also suffers from the disadvantage that it is extremely difficult to align the  
25 hollow portion of the tubular bead regularly in the axis thereof. If the flow path of the foamable material would be curved or the flow of the foamable material would become irregular, for example, the gaseous cores do not always

flow along the axis of the tubular bead so that there may be the occasion that the hollow portions of the tubular bead extending along the axis thereof are not formed in an ideal shape as intended. In addition, there may be the  
5 occasion that the resulting bead may be rendered poor in quality because a larger hollow portion may be formed if the gaseous core would be penetrated into the surrounding area of the tubular bead and then foam therein.

#### SUMMARY OF THE INVENTION

10 Therefore, the present invention has been accomplished in order to overcome or improve the foregoing defects present in the prior art technology, and it has the object to provide a method for molding a bead and an apparatus for carrying out the method for molding the bead,  
15 which can more stably mold the hollow bead or foamed bead of high quality having the advantages that they are low in compressive stress, lightweight, and high in strength, as comparable to conventional hollow bead and that they have little or no defective portion.

20 The present invention has another object to provide a bead-molding method and apparatus so adapted as to comply with a large-scale production and flexible applications to versatile usages by readily allowing the bead to be automatically applied and molded into an irregular form  
25 onto a work, while conventional technology has otherwise applied manually a work with a foamed molding tape or a regular form of hollow tubular bead.

Further, the present invention has another object to

provide a method and an apparatus for molding the bead, which can accomplish each of the above objects of the present invention in a very simplified manner and structure.

In order to achieve the objects, the present invention in a first aspect provides a method for molding the hollow bead into a predetermined shape from a highly viscous material that is fluid in a high-speed flow region and high in the ability of retaining the shape into which it is located in a low-speed flow region, the bead-molding method comprising a gas stream forming step for forming a gas stream flowing in a one direction; a material stream forming step for forming a high speed flow of a highly viscous material stream in an outer peripheral space enclosing the gas stream; and a hollow bead molding step for molding the hollow bead into an irregular shape by reducing the high speed flow of the highly viscous material stream to its low speed flow, while fluidizing the highly viscous material flowing in the outer peripheral space outside the gas stream.

In the first aspect of the present invention, the gas stream flowing in the one direction is created in the gas stream forming step, and the highly viscous material stream flowing at a high speed flow through the outer peripheral space enclosing the gas stream is created in the material stream forming step. The highly viscous material stream is highly fluid or flowable when it is located in the high speed flow region, so that it can be molded into any optional form in a more flexible manner in the outer

peripheral space enclosing and about the gas stream, for example, by changing the direction of the highly viscous material stream. It is preferred, however, that the direction of the highly viscous material stream is the  
5 direction substantially parallel to the direction in which the gas stream flows, to say, in substantially the same direction.

In the hollow bead molding step in the first aspect, the highly viscous material stream flowing in the high-  
10 speed flow region can be molded into a given shape in a flexible manner by taking advantage of the fluidity of the highly viscous material, and the shape of the highly viscous material stream into the highly viscous material was applied and molded is retained as it is as the high  
15 speed flow of the highly viscous material stream is dropped to the low-speed flow region and eventually to zero. At this instance, the gas stream flows at the central portion while fluidizing the highly viscous material into an irregular shape so as to maintain the status in which the  
20 highly viscous material is flowing around the gas stream. This configuration can mold the hollow bead into any optional shape that has its inner portion rendered hollow and the surrounding portion enclosed with the highly viscous material. This bead-molding step can readily mold,  
25 for instance, hollow bead in a slenderly elongated tubular form and curved hollow bead.

The present invention in a second aspect provides a method for molding a hollow bead from a foamable material

for molding a foamed body, which comprises a gas stream forming step for forming a gas stream flowing in a one the direction; a material stream forming step for forming a highly viscous material stream in an outer peripheral space enclosing the gas stream, the highly viscous material stream flowing in the same direction as the direction of the gas stream; and a hollow bead molding step for molding the hollow bead into an irregular shape while foaming the foamable material flowing through the outer peripheral space.

In the second aspect of the present invention, the hollow bead can be molded into any optional shape by the processes similar to the above processes in the first aspect, the hollow bead having its inside rendered hollow and its surrounding portion enclosed with the foamed body.

The present invention in a third aspect provides a method for molding the hollow bead into a shape of the applying position by applying the hollow bead on the work while following the work, in the hollow bead molding step in the first and second aspects, respectively.

In the third aspect of the present invention, as the highly viscous material stream or the foamable material stream in the high speed flow region reaches the applying position, the flow speed of the material stream is rapidly reduced up to a low speed and eventually to zero. At the same time, the viscosity of the material stream is caused to increase rapidly and assumes a certain shape, to say, a shape that the highly viscous material stream or the

foamable material stream encloses the gas stream.

Furthermore, the highly viscous material stream or the foamable material stream is set into that shape. As the highly viscous material stream or the foamable material stream is transferred in this state along and following the shape of the applying position, the material is applied and molded into the shape that complies with the shape of the applying position.

Upon applying the material on the work, the hollow bead applied and molded can be tackied or adhesived to the work by using the highly viscous material or the foamable material having an tackinessly or adhesive property, as in a fourth aspect of the present invention.

Further, in order to form the one-way flow of the gas stream and the material stream flowing around the gas stream, a discharging device may be arranged and configured as in a fifth aspect of the present invention so as to perform the methods as configured in the first to fourth aspects as described above. The discharging device has an inner nozzle elongated at a tip portion and an outer nozzle elongated so as to enclose an outer periphery of the inner nozzle. In this aspect, the gas stream forming step is preferably configured such that the gas stream is allowed to flow in a one direction by discharging gases from the inner nozzle, and the material stream forming step is preferably configured discharging the highly viscous material or foamable material stream from the outer nozzle to form the material stream outside and around the gas

stream in the same direction as the gas stream flows.

Moreover, in a sixth aspect as a preferred configuration of the third or fourth aspect as described above, a discharging device is provided which has an inner  
5 nozzle elongated at a tip portion and an outer nozzle elongated so as to enclose an outer periphery of the inner nozzle in order to the method in the third or fourth aspect of the present invention. In the gas stream forming step, gases are discharged from the inner nozzle to form a gas  
10 stream flowing in a one direction. On the other hand, in the material stream forming step, the highly viscous material or the foamable material is discharged from the outer nozzle in the form of a stream that flows in the same direction as the gas stream flows while enclosing the gas  
15 stream. Further, in the bead molding step, the hollow bead is applied and molded into a shape corresponding to the shape of the applying position by transferring the inner nozzle and the outer nozzle along a predetermined locus following the shape of the applying position while  
20 discharging the highly viscous material or the foamable material onto the work.

In accordance with the present invention, the gas stream is formed to flow in the one direction and the highly viscous material stream is formed to flow in a high  
25 speed flow region about and enclosing the gas stream, while the highly viscous material stream is molded into a predetermined shape while slowing the high speed flow of the highly viscous material stream down to the low speed



flow as the highly viscous material is being rendered fluid. Therefore, this aspect of the present invention can present the advantages that the hollow bead of high quality can be molded into an optional shape without any or less defects  
5 in a ready and stable manner. Moreover, the hollow bead can provide a sealing portion having an appropriate level of elasticity because they are hollow inside so that they are lightweight and they require only a small amount of stress upon compression.

10 It is noted herein, however, that the method for molding the hollow bead in the aspects as described above can also be applied to a seventh aspect and subsequent aspects where a foamed bead with its inner portion filled with a foamable material and its surrounding and outer  
15 portion covered or applied with the highly viscous material.

In a seventh aspect of the present invention, there is provided a bead-molding method for molding the foamed bead into a given shape from a foamed body covered with the highly viscous material that is fluid in the form of a  
20 stream in a high speed flow region and can retain its shape into which the highly viscous material is applied when it is in a low speed flow region. The bead-molding method in this aspect is composed of a foamable material stream forming step for forming a foamable material stream flowing  
25 in a one direction, which can forms the foamed body; a material stream forming step for forming a highly viscous material stream in a high speed flow region within an outer peripheral space enclosing and about the foamable material

stream; and the bead molding step for molding the foamed bead into an irregular shape by reducing the high speed flow of the highly viscous material to the low speed flow thereof while fluidizing the highly viscous material  
5 flowing around and about the foamable material stream and, at the same time, by foaming the foamable material.

In an eighth aspect, the foamed bead are molded into a given shape along and following the shape of the work by transferring the work along its shape while applying the  
10 work with the foamable material stream and the highly viscous material stream, in accordance with the seventh aspect.

The present invention in a ninth aspect is directed to the bead-molding step wherein the foamed bead applied  
15 and molded is tackied or adhesived to the work by using the highly viscous material having an tacky or adhesive property tackiness.

In a tenth aspect of the present invention, the bead-molding method in one of the seventh to ninth aspects is  
20 modified in such a manner that the discharging device is disposed which has an inner nozzle elongated at its tip portion and an outer nozzle elongated about and enclosing the outer periphery of the inner nozzle; the foamable material stream flowing in the one direction is formed by  
25 discharging the foamable material from the inner nozzle in the foamable material stream forming step; and the highly viscous material stream flowing in the same direction as the foamable material stream and about and enclosing the

foamable material stream by discharging the highly viscous material from the outer nozzle in the material stream forming step.

The present invention in an eleventh aspect is  
5 directed to the bead-molding method modified from the method in the eighth or ninth aspect, which includes a discharging device having an inner nozzle elongated at its tip portion and an outer nozzle elongated about and enclosing the outer periphery of the inner nozzle; the  
10 foamable material stream forming step for forming the foamable material stream flowing in the one direction by discharging the foamable material from the inner nozzle; the material stream forming step for forming the highly viscous material stream flowing in the same direction as  
15 the foamable material stream and about and enclosing the foamable material stream by discharging the highly viscous material from the outer nozzle; and the bead molding step for molding the foamed bead into a given shape corresponding to the shape of the work by transferring the  
20 discharging device along a predetermined locus following the shape of the work while discharging the foamable material stream and the highly viscous material stream from the inner nozzle and the outer nozzle, respectively, onto the work.

25 In accordance with any one of the seventh to eleventh aspects of the present invention, there are formed the foamable material stream flowing in the one direction and the highly viscous material stream flowing in the high-

speed flow region while enclosing the foamable material stream in such a way that the foamed bead are molded by transferring the highly viscous material stream in the high-speed flow region to the low-speed flow region while rendering the highly viscous material fluid. Therefore, the method according to this aspect can present the advantages that the foamed bead of high quality can be molded into an optional shape without any or less defects in a ready and stable manner. Moreover, the foamed bead is of a hollow foamed body so that the foamed bead can provide a sealing section that is lightweight, has a small stress against compression as well as an appropriate level of softness. Furthermore, the foamed bead can provide the foamed body with improved waterproof, airtight and shock absorbing performance, as compared with a foamed body made of a conventional bead that is not covered or enclosed with any highly viscous material.

Further, the discharging device in the sixth or eleventh aspect can be used as a system for automatically applying and molding the hollow bead or the foamed bead. Moreover, as in a twelfth aspect, the discharging device can be mounted on a manipulator disposed movable to a desired position in response to a control signal, and the bead-molding step is arranged to automatically apply and mold the hollow bead or the foamed bead on the work of plural work members one after another being carried on a manufacturing line by controlling the discharging position of the discharging device by means of the manipulator.

Furthermore, in the twelfth aspect, it is preferred to control the manipulator so as to bring the actually applying position of work the bead by the discharging device substantially into agreement with a predetermined target applying position by detecting the actual applying position thereof, as in a thirteenth aspect of the present invention. This control enables applying the hollow bead or the foamed bead at the accurate positions following the work.

Moreover, in the twelfth or thirteenth aspect, it is preferred to automatically decide whether the bead is applied and molded in a favorable fashion by picking up an image of the bead applied and molded in a favorable fashion and comparing the picked-up image of the bead with a pre-stored reference image of the bead applied and molded in a favorable fashion, as in a fourteenth aspect,

By enabling the automatic decision on the bead molded in a favorable fashion, the operator can immediately determine the bead with defects so that he can carry out the subsequent proceeding without delay.

Further, in any one of the twelfth to fifteenth aspects, it is preferred to use an opening closing member capable of opening and closing a given opening as the work member as in a fifteenth aspect.

In the fifteenth aspect, it is further preferred to apply and mold the hollow bead or the foamed bead on the work and form a sealing section between the opening and the opening/closing member, as in a sixteenth aspect, the work

being a site nearby and along the edge portion of the opening/closing member.

In the sixteenth aspect, a foamed body with the inside rendered hollow or rich of gaseous bubbles is used, 5 so that the sealing section becomes lightweight and has a small amount of stress against compression as well as has an appropriate level of elasticity. These properties can provide the sealing section with improved sealing performance when the opening/closing member is closed and 10 provide for the easy operations for opening and closing the opening/closing member.

As described above, in each of the twelfth to sixteenth aspects of the present invention, the hollow bead or the foamed bead can be applied and molded into any 15 optional shape on the work automatically, so that the bead-molding method according to the present invention can deal with a large-scale production of molded members and versatile requirements for applications.

Then, a description will be given below regarding a 20 bead-molding apparatus for conducting the bead-molding method as in the following seventeenth to thirtieth aspects of the present invention.

For the bead-molding apparatus for molding the hollow bead as in the seventeenth aspect of the present invention, 25 the apparatus includes a discharging device having an inner nozzle elongated at its tip portion, an outer nozzle elongated about and enclosing an outer periphery of the inner nozzle, a first inlet connecting with the inner

nozzle, and a second inlet connecting with the outer  
nozzle; a gases feed unit for feeding gases to the  
discharging device through the first inlet; and a material  
feed unit for feeding a highly viscous material or a  
5 foamable material to the discharging device through the  
second inlet, the highly viscous material being fluid in  
the form of a stream in a high speed flow region and  
capable of retaining the shape into which the material is  
molded. As in the seventeenth aspect of the present  
10 invention, the apparatus of molding the hollow bead can be  
realized in such a very simple structure.

In the eighteenth aspect, the bead-molding apparatus  
of the present invention includes discharging device  
including an inner nozzle disposed extending at a tip  
15 portion, an outer nozzle disposed extending about and  
enclosing an outer periphery of the inner nozzle, a first  
inlet connecting with the inner nozzle, and a second inlet  
connecting with the outer nozzle; a foamable material feed  
unit for feeding a foamable material to the discharging  
20 device through the first inlet; and a material feed unit  
for feeding a highly viscous material to the discharging  
device through the second inlet, the highly viscous  
material being fluid in the form of a stream in a high  
speed flow region and capable of retaining a shape into  
25 which it is molded in a low speed flow region.

For the foamable material feed unit in the eighteenth  
aspect, it is preferred to feed a mixture of gases with the  
highly viscous material as the foamable material, as in a

nineteenth aspect.

As in a twentieth aspect of the present invention, the foamable material feed unit in the nineteenth aspect includes a plurality of piston pumps arranged so as to perform an suction stroke and a extrusion stroke by reciprocally moving a piston in a cylinder; a foaming gas injection unit for injecting gases under a predetermined pressure into the cylinder; and a pump control unit for controlling the plurality of the piston pumps in such a manner that each of the plurality of the piston pumps is arranged to conduct the suction stroke for feeding gases and with the highly viscous material after the suction stroke and to conduct the extrusion stroke for discharging the mixture of the gases with the highly viscous material as the foamable material as well as that a time difference is provided for the extrusion stroke of each of the plurality of the piston pumps so as to continually discharge a predetermined quantity of the foamable material.

In the present invention in the twentieth aspect, the cylinder pump of a predetermined flow amount are used, and the gases are first introduced followed by the introduction of the highly viscous material, so that the pressure of the gases can be rendered lower and the highly viscous material can be mixed with the gases at an accurate mixing rate. Furthermore, the plural cylinder pumps each having a predetermined flow amount are arranged with a time difference so that they can discharge the mixture continually at a predetermined quantity in accordance with



given control procedures, thereby enabling applying and molding the foamed bead in a uniform and even manner.

Further, in a twenty-first aspect of the present invention, the foamable material feed unit is further  
5 provided with a dispersing tubular path for dispersing gaseous bubbles in minute at a discharging process.

Moreover, in the twenty-first aspect, as the mixture is passing through the dispersing tubular path, a relative speed difference is caused to occur between the central  
10 portion and the peripheral portion, i.e., a portion close to the inner wall section of the tubular path. This relative speed difference assists in dispersing the gaseous bubbles in the mixture into more fine particle and this mechanism can further improve the quality of the foamed  
15 bead.

In the present invention in a twenty-second aspect, the discharging device as in each of the seventeenth to twenty-first aspect is configured such that a variation of each of the inner nozzle and the outer nozzle in the inner  
20 wall diameter becomes smaller over the length extending from the connection end section with the body of the discharging device to the tip portion with a predetermined inner dimension.

In the twenty-second aspect of the present invention,  
25 the variation in the inner wall diameter is defined to become smaller, so that a loss in pressure of the material stream within the nozzle can be minimized under the given conditions of the nozzle size.

A twenty-third aspect of the present invention is characterized by the inner nozzle and the outer nozzle of the discharging device in each of the seventeenth to twenty-second aspects, each of which has the outer nozzle wall portion containing the outermost edge section comprised of an slant surface joining at an acute angle with respect to the direction in which the highly viscous material or the foamable material is discharged.

More specifically, in the twenty-third aspect, the outer wall portion of the nozzle containing the outermost edge section is inclining at an acute angle with respect to the flow of the material stream, so that the material becomes unlikely to be adsorbed at the outer nozzle wall portion while the material is being discharged from the nozzle outlet.

In a twenty-fourth aspect, the present invention in each of the seventeenth to twenty-third aspect is characterized by a first control valve and a second control valve for controlling the opening and closing of the passages extending from the first inlet to the inner nozzle and from the second inlet to the outer nozzle, respectively, the first and second control valves being disposed in the corresponding passages.

The first and second control valves in this aspect may be opened and closed, for example, by a pneumatic cylinder, a hydraulic cylinder or an electrically-drivable motor.

Further, in a twenty-fifth aspect, the discharging

device in the twenty-fourth aspect can be hand-carried and the first and second control valves can be opened and closed by manual on-off operations.

These configurations allow the operator to operate  
5 the bead-molding apparatus manually. Therefore, the hollow bead or the foamed bead can be applied without much difficulty even at a very narrow place where a large-size manipulator cannot be used for application and so on.

Moreover, in order to automatically control the  
10 discharging of the bead by the discharging device, a twenty-sixth aspect of the present invention is configured such that the first and second control valves as in the twenty-fourth aspect is arranged so as to be opened and closed in response to an instruction signal.

15 The present invention in a twenty-seventh aspect is characterized in that the discharging device in the twenty-sixth aspect is mounted on a top portion thereof and is further provided with a manipulator disposed so as to be movable to a desired position in response to a control  
20 signal and with a control unit for automatically control the movement of the manipulator and the discharging of the discharging device in accordance with a predetermined program.

In a twenty-eighth aspect, the control unit in the  
25 twenty-seventh aspect is arranged so as to automatically control the movement of the manipulator and the discharge of the discharging device so as to automatically apply and mold the hollow bead or the foamed bead on a work of each

of a plurality of work members being carried on a manufacturing line one after another.

The present invention in the twenty-eighth aspect can realize a system suitable for automatically applying and  
5 molding the hollow bead or the foamed bead of high quality on the work members on a large scale.

Further, in the twenty-eighth aspect, it is preferred as in a twenty-ninth aspect of the present invention that that the discharging device is further provided with a  
10 detection unit for detecting an actual applying position of work the bead by the discharging device and that the control unit is arranged to control the manipulator so as for the actual applying position thereof to be brought substantially into agreement with a predetermined target on  
15 the work.

Moreover, as in a thirtieth aspect, it is preferred that the apparatus in the twenty-ninth aspect is further provided with an image pick-up unit for picking up an image of the bead applied and molded on the work and that the  
20 control unit is arranged to automatically decide whether the bead is applied and molded in a favorable fashion by comparing the picked-up bead image with a pre-stored reference image of the bead applied and molded in a favorable fashion.

25 It is to be noted herein that the present invention in each of the above aspects can be extended to a method and an apparatus wherein a hot melt material is used whose fluidity can be controlled by temperature, in place of the

flow speed.

For instance, the present invention in a thirty-first aspect is directed to a bead-molding method for molding hollow bead from a hot melt material that is fluid in the form of a stream in a middle-high temperature region and can retain the shape into which the bead is molded in a middle-low temperature region, and the bead-molding method comprises a gas stream forming step for forming a gas stream flowing in a one direction; a material stream forming step for forming a hot melt material stream in the middle-high temperature region within an outer peripheral space about and outside so as to enclose the gas stream; and a bead molding step for molding the hollow bead into an irregular shape by cooling the middle-high temperature of the hot melt material to the middle-low temperature while fluidizing the hot melt material flowing in the outer peripheral space about the gas stream.

In the thirty-first aspect of the present invention, the gas stream is formed in the gas stream forming step and the stream of the hot melt material is formed in the outer peripheral side about and enclosing the gas stream in the material stream forming step. The hot melt material stream is highly fluid in the middle-high temperature region, so that the hot melt material can be applied and molded flexibly into a given shape by taking advantage of the high fluidity and molded into the given shape as it was by cooling the temperature of the hot melt material from the middle-high temperature region to the middle-low

temperature region.

It is to be noted herein that the middle-high temperature region as referred to herein means to include a temperature range from approximately 60°C (333 K) to  
5 approximately 200°C (473 K) and the middle-low temperature region as referred to herein means to include a temperature range from room temperature to approximately 150°C (423 K). Further, it is preferred that there is a temperature difference between the middle-high temperature region and  
10 the middle-low temperature region by approximately 5°C or higher.

It should further be noted herein that the present invention in the aspect relating to the hot melt material can also be used in a similar manner to a foamable hot melt  
15 material obtainable by foaming the hot melt material.

Therefore, the present invention in a thirty-second aspect is directed to a bead-molding method for molding the hollow bead from the foamable hot melt material for forming a foamed body, and the bead-molding method may comprises a  
20 gas stream forming step for forming a gas stream flowing in a one direction; a material stream forming step for forming the foamable hot melt material stream flowing in the same direction as the gas stream within an outer peripheral space about and outside so as to enclose the gas stream;  
25 and a bead molding step for molding the hollow bead into an irregular shape by foaming the foamable hot melt material flowing in the outer peripheral space about the gas stream.

In a thirty-third aspect, the present invention in

the thirty-first aspect or the thirty-second aspect is characterized in that the hollow bead are applied and molded into a shape corresponding to and following the shape of the work by transferring the hot melt material stream or the foamable hot melt material stream along and following the shape of the work while applying the material stream onto the work in the bead-molding step.

The present invention in a thirty-fourth aspect is characterized in that, in the thirty-third aspect, the discharging device is disposed which has an inner nozzle elongated at its tip portion and an outer nozzle elongated about and enclosing an outer periphery of the inner nozzle; the gas stream forming step is to form the gas stream flowing in a one direction by discharging the gases from the inner nozzle; the material stream forming step is to form the hot melt material stream or the foamable hot melt material stream in the same direction as the gas stream so as to enclose the gas stream by discharging the hot melt material or the foamable hot melt material from the outer nozzle; and bead-molding step for molding the hollow bead into a shape corresponding to and following the shape of the work by transferring the material stream along a given locus while discharging the gas stream and the material stream toward and onto the work from the respective inner and outer nozzles.

Moreover, the present invention in a thirty-fifth aspect is directed to a bead-molding method for molding a foamed bead comprised of a foamed body covered with a hot

melt material that is fluid in the form of a stream in a middle-high temperature region and can retain the shape into which it is molded in a middle-low temperature region, and the bead-molding method comprises a foamable material stream forming step for forming a stream of a foamable hot melt material for forming the foamed body; a material stream forming step for forming a stream of the hot melt material flowing in the middle-high temperature region within an outer peripheral space the foamable hot melt material stream about and enclosing the foamable hot melt material stream; and a bead-molding step for molding the foamed bead into an irregular shape by cooling the middle-high temperature region to the middle-low temperature region while fluidizing the hot melt material stream flowing within the outer peripheral side outside and about the foamable hot melt material stream and foaming the foamable hot melt material.

In a thirty-sixth aspect, the present invention is characterized in that the bead-molding step in the thirty-fifth aspect is further arranged so as to mold the foamed bead into a shape corresponding to and along the shape of the work by applying the hot melt material stream or the foamable hot melt material stream onto the work while transferring the material stream along and following the shape of the work.

In a thirty-seventh aspect, the present invention in the thirty-fifth or thirty-sixth aspect is configured such that a discharging device is disposed which has an inner



nozzle elongated at a tip portion thereof and an outer  
nozzle elongated about and enclosing an outer periphery of  
the inner nozzle, wherein the foamable stream forming step  
forms the foamable hot melt material stream in the one  
5 direction by discharging the foamable hot melt material  
from the inner nozzle; and the material stream forming step  
forms the hot melt material stream in the same direction of  
the direction of the foamable hot melt material stream and  
enclosing the foamable hot melt material by discharging the  
10 hot melt material from the outer nozzle.

The present invention in a thirty-eighth aspect  
includes a discharging device including an inner nozzle  
elongated at a tip portion thereof and an outer nozzle  
elongated enclosing an outer periphery of the inner nozzle;  
15 wherein the foamable stream forming step forms the foamable  
hot melt material stream in the one direction by  
discharging the foamable hot melt material from the inner  
nozzle; the material stream forming step forms the hot melt  
material stream in the same direction as the direction of  
20 the foamable hot melt material stream by discharging the  
hot melt material from the outer nozzle; and the bead  
molding step for molding foamed bead into a shape  
corresponding to and following the shape of the work by  
transferring the material stream along a given locus while  
25 discharging the foamable hot melt material from the inner  
nozzle and the hot melt material the outer nozzle,  
respectively.

Further, in a thirty-ninth aspect, the bead molding

method in the thirty-seventh or thirty-eighth aspect is characterized in that the discharging device is mounted on a manipulator disposed to be movable to a desired position in response to a control signal, and in the bead molding  
5 step, the hollow bead or the foamed bead are automatically applied and molded on the applying position of a plurality of work members being carried on a manufacturing line one after another by controlling the discharging position of the discharging device by means of the manipulator.

10 The present invention in a fortieth aspect provides a bead molding apparatus for forming the hollow bead, which includes a discharging device comprised of an inner nozzle elongated at a tip portion thereof, an outer nozzle elongated about and enclosing an outer periphery of the inner  
15 nozzle, a first inlet connecting with the inner nozzle, and a second inlet connecting with the outer nozzle; a gases feed unit for feeding gases to the discharging device through the first inlet; and a material feed unit for feeding a hot melt material or a foamable hot melt material  
20 to the discharging device through the second inlet, the hot melt material being fluid in the form of a stream in a middle-high temperature region and can retain the shape into which the material is molded in a middle-low temperature region.

25 Moreover, the present invention in a forty-first aspect is directed to a bead molding apparatus for forming foamed bead and characterized in that the apparatus includes a discharging device comprised of an inner nozzle

elongated at a tip portion thereof, an outer nozzle  
elongated about and enclosing an outer periphery of the  
inner nozzle, a first inlet connecting with the inner  
nozzle, and a second inlet connecting with the outer  
5 nozzle; a first material feed unit for feeding a foamable  
hot melt material to the discharging device through the  
first inlet; and a second material feed unit for feeding a  
hot melt material to the discharging device through the  
second inlet, the hot melt material being fluid in the form  
10 of a stream in a middle-high temperature region and can  
retain the shape into which the material is molded in a  
middle-low temperature region.

In a forty-second aspect, the present invention is  
characterized in that the first material feed unit feeds a  
15 mixture of the gases with the hot melt material as the  
foamable hot melt material in the forty-first aspect of the  
present invention.

Other objects, features and advantages of the present  
invention will become apparent in the course of the  
20 following description with reference to the accompanying  
drawings.

#### BRIEF DESCRIPTION OF THE DRAWINGS

The present invention will be understood more  
clearly by the following detailed description on each of  
25 embodiments of the present invention with reference to the  
accompanying drawings.

Fig. 1 is an illustration showing an outline  
configuration of an automatically bead applying and molding

system in accordance with a first embodiment of the present invention.

Fig. 2 is a sectional view showing an inner structure of a discharging device of the automatically bead applying and molding system in accordance with the first embodiment of the present invention.

Fig. 3 is a sectional view showing details of the structure of a nozzle and part around the nozzle of the discharging device of Fig. 2.

Fig. 4 is an exploded view showing parts of the nozzle of Fig. 3.

Fig. 5 is a block diagram showing a specific configuration of a highly viscous material feed unit for use with the automatically hollow bead applying and molding system according to the first embodiment of the present invention.

Fig. 6 is a block diagram showing a specific configuration of a gases feed unit for use with the automatically hollow bead applying and molding system according to the first embodiment of the present invention.

Fig. 7 is a view for description of a process for applying and molding the hollow bead; wherein (a) is a schematic view showing the applying and molding process and (b) is perspective and sectional views showing the hollow bead formed by the applying and molding process.

Fig. 8 is a plan view of opening/closing member for a control board as a work for applying the hollow bead by the automatically hollow bead applying and molding system

according to the first embodiment of the present invention;  
wherein (a) is directed to the control board before  
applying and (b) is directed to the control board after  
applying.

5           Fig. 9 is a view showing an outline configuration of  
an automatically foamed bead applying and molding system  
according to a second embodiment of the present invention.

10           Fig. 10 is a block diagram showing a specific  
configuration of a foamed material feed unit for use with  
the automatically foamed bead applying and molding system  
according to the second embodiment of the present invention.

Fig. 11 is a timing chart showing the action timing  
of a cylinder pump of the foamed material feed unit as  
shown in Fig. 10.

15           Fig. 12 is an illustrative view showing a bead  
molding device according to a third embodiment of the  
present invention.

Fig. 13 is a view showing the structure of  
discharging device for explaining prior art technology.

## 20   DESCRIPTION OF THE PREFERRED EMBODIMENTS

The present invention will be described in more  
detail by way of embodiments with reference to the  
accompanying drawings.

### First Embodiment:

25           Fig. 1 shows an outline configuration of a system for  
automatically applying and molding a hollow bead in  
accordance with the first embodiment of the present  
invention. The system is adapted to apply and mold the

hollow bead suitable on a large scale for use in automatically applying and molding the hollow bead along an edge portion of a work for a control board.

In Fig. 1, there is shown a system 1 for automatically applying and molding the hollow bead, which includes a discharging device 10 for discharging feed gases and a highly viscous material from a nozzle 12 to form a hollow bead, a gases feed section 14 for feeding the gases to the discharging device 10, a highly viscous material feed section 16 for feeding the high viscous material to the discharging device 10, the highly viscous material that is fluid in the form of a stream in a high speed flow region and can retain the shape into which it is molded in a low speed flow region, and a compressive air control section 18 for controlling the opening and closing of a discharging valve (as will be described later) disposed inside the discharging device 10 by feeding compressive air to the discharging device 10 and controlling the compressive air pressure therein.

In order to adapt the discharging device 10 to the automatic applying and molding on a large scale, the discharging device 10 is mounted on a tip portion of a manipulator 60 through a flange or any other suitable part, the manipulator 60 being arranged so as to transfer the tip portion thereof to a desired position located within a predetermined range in response to an control signal. The bead applying and molding system 1 may include a belt conveyor 65, a detection sensor 25, an image pick-up sensor

26, a controller 22, a memory unit 24, and an I/O port 20.  
The belt conveyor 65 can carry plural opening/closing  
member 23 loaded on an endless belt 67 one after another to  
the predetermined applying position in which the  
5 opening/closing member 23 can be applied. The detection  
sensor 25 can detect the predetermined applying position in  
which the opening/closing member 23 loaded on the belt  
conveyor 65 is to be applied. The image pick-up sensor 26  
can pick up images of the opening/closing member 23 and the  
10 hollow bead applied and molded on the opening/closing  
member 23. The controller 22 can control and manage the  
entire operations of the bead applying and molding system 1.  
The memory unit 24 is to store data necessary for applying  
and molding the hollow bead. The I/O port 20 can control  
15 input and output interfaces between the controller 22 and  
other structuring elements.

These structuring elements can be realized by known  
technology. For instance, the detection sensor 25 may be  
configured as a combination of a light emitting diode (LED)  
20 capable of emitting light to the predetermined applying  
position with a phototransistor disposed so as to detect  
the light emitted from the LED. With this configuration of  
the detection sensor 25, the phototransistor can detect the  
blocking of the passage of the light from the LED by the  
25 work 23 so that the blocking of the light passage may be  
determined as the location of the work 23 in the  
predetermined applying position. Further, the image pick-  
up sensor 26 may be comprised of a CCD (charge coupled

device). Moreover, the controller 22 may be composed of a micro-processor or a personal computer, for example, which can carry out various kinds of processing including image analysis using CCD images and a so-called PI (proportional-  
5 plus-integral) control.

Next, a description will be given regarding the detailed structure of the discharging device 10 with reference to Figs. 2 to 4.

Fig. 2 shows a sectional view showing the discharging  
10 device 10. As shown in Fig. 2, the discharging device 10 has a discharging unit for discharging a highly viscous material, including a pneumatic cylinder 13 disposed in a body 33 thereof, a piston 17 disposed to reciprocally move within the pneumatic cylinder, a rod 19 elongated from a  
15 surface at the nozzle side of the piston, a material inlet 11a connected to the highly viscous material feed section 16 (Fig. 1), a material chamber 27 for storing the highly viscous material fed from the material inlet before discharging, a valve path 28 formed from and through a side  
20 portion of the chamber at its nozzle side, an inner material path 29 branched from the valve path up to a base portion of the nozzle 12, and a material nozzle line 31 elongated from the inner material path 29 up to a tip portion of the nozzle.

25 The body 33 of the discharging device 10 has compressive air pressure feed inlets 15a and 15b through which compressive air pressure is fed from the outside into the body thereof. The feed inlets 15a and 15b are disposed,



respectively, connecting with positions close to the top dead center of the pneumatic cylinder 13 and the bottom dead center thereof. The compressive air pressure feed inlets 15a and 15b are connected to the compressive air pressure control section 18 (Fig. 1) through a pneumatic line and controlled to feed air from the compressive air pressure control section 18. As the compressive air pressure fed to the compressive air pressure feed inlet 15a is decreased while the compressive air pressure fed to the compressive air pressure feed inlets 15b is increased, the piston 17 is moved in the direction indicated by arrow P and reaches the top dead center. On the contrary, as the compressive air pressure fed to the compressive air pressure feed inlet 15a is increased while the compressive air pressure fed to the compressive air pressure feed inlets 15b is decreased, the piston 17 is moved in the direction indicated by arrow Q and reaches the bottom dead center. As described above, the piston 17 is controlled by the compressive air pressure control section 18 so as to reciprocally move between the top dead center and the bottom dead center of the pneumatic cylinder 13.

The rod 19 is disposed in a rod hole 35 extending and connecting between the pneumatic cylinder 13 and the material chamber 27 inside the body portion, and a tip portion of the rod 19 is elongated in the material chamber 27. As the piston 17 moves in the direction P and approaching the top dead center, the tip portion of the rod 19 is allowed to enter into the valve path 28 and assume

the state as indicated in Fig. 2, thereby blocking the passage of the highly viscous material from the material chamber 27 to the nozzle 12. In other words, the highly viscous material fed is caused to stay within the material chamber 27 and cannot be discharged from the nozzle 12. On the other hand, as the piston 17 moves in the direction Q and approaching the bottom dead center, the tip portion of the rod 19 is released from the valve path 28 and the passage of the highly viscous material from the material chamber 27 to the nozzle 12 is opened. Therefore, the highly viscous material fed can be discharged from the material chamber 27 through the inner material path 29 and the nozzle line 31 into the nozzle 12, followed by discharging the highly viscous material from the nozzle 12.

The discharging device 10 has a gas discharging unit including a gas inlet 11b connected to the gas feed section 14 (Fig. 1) for receiving the supply of gases therefrom, an inner gas path 30 for allowing the passage of the gases fed from the gas inlet 11b within the body thereof, and a gas nozzle line 32 disposed in the nozzle 12 and connected to the inner gas path 30. The inner path of the gas inlet 11b is provided with a gas control valve 11c for controlling the opening and closing of the gas inlet 11b. As the gas control valve 11c is opened, the gases fed from the gas feed section 14 are discharged from the tip of the nozzle 12 through the inner gas path 30 and the gas nozzle line 32. On the contrary, although a matter of course, as the gas control valve 11c is closed, the gases fed therefrom are

not discharged from the nozzle 12. The gas control valve 11c may be controlled so as to be opened and closed by means of an electrically-driven motor (not shown) or any other suitable unit.

5 Further, the discharging device 10 is provided with a flange 34 at its rear end portion, and the discharging device 10 is mounted on the manipulator 60 through the flange 34.

Fig. 3 shows the details on the sectional view of the  
10 nozzle 12. As shown in Fig. 3, the nozzle 12 is of a double nozzle structure consisting of an inner nozzle 36 elongated slenderly over the entire length thereof so as to allow discharging the gases in the one direction, and an  
outer nozzle 38 elongated slenderly over the entire length  
15 thereof so as to allow discharging the highly viscous material in a pressured state in the one direction. The gas nozzle line 32 is disposed inside the inner nozzle 36, and the material nozzle line 31 is interposed between the  
outer wall of the inner nozzle 36 and the inner wall of the  
20 outer nozzle 38 enclosing the material nozzle line 31. In order to reduce a loss in pressure upon the supply of the highly viscous material under pressure, the inner wall of the material nozzle line 31 is rendered very smooth and is  
formed so as to make a variation in inner line dimension  
25 smaller. In order to do this, for instance, the inner wall of the material nozzle line 31 may be formed so as to compensate the difference in dimension between the size of the nozzle at its tip predetermined to adapt to the size of

the hollow bead and the size of a connection portion  
between the nozzle 12 and the body 33 for a fine variation  
in dimension at any portion of the nozzle over its entire  
nozzle length. The gas nozzle line 32 is set to become  
5 identical in size over the entire nozzle length.

Moreover, the outer nozzle 38 is provided with a  
slanting surface 39 so as to intersect with an outer wall  
portion extending rearward from the outermost tip at an  
acute angle with respect to the direction of discharging  
10 the highly viscous material. On the other hand, the inner  
nozzle 36 is provided with a slanting surface 37 so as to  
intersect with an inner wall portion extending rearward  
from the outermost tip thereof at an acute angle with  
respect to the direction of discharging the highly viscous  
15 material. As these slanting surfaces 37 and 39 are formed  
each at an acute angle with respect to the direction in  
which the highly viscous material stream discharged from  
the outer nozzle 38 flow, an occurrence of dragging of the  
highly viscous material due to the high viscosity of the  
20 highly viscous material attached to the discharging outlet  
can be prevented, thereby resulting in the reduction in a  
loss in pressure.

As shown in Fig. 3, each of the discharging paths 31  
and 32 of the nozzle 12 is of coaxially circular form in  
25 section when taken in the direction perpendicular to the  
axis of the nozzle.

Fig. 4 shows parts of the nozzle 12. As shown in Fig.  
4, a structuring portion containing the inner nozzle 36 and

the outer nozzle 38 may be divided into two structuring parts, one structuring part being as an inner nozzle part 45a and an outer nozzle part 45b. The inner nozzle part 45a may be composed of the inner nozzle 36 in the form of a truncated cone and a flange portion 42 connecting the inner nozzle 36 to the body 33. The flange portion 42 may include a plurality of apertures 40 through which the highly viscous material can be discharged to the material nozzle line 31 when they are aligned with a plurality of apertures of the inner material path 29 and further include a raised portion 46 and two cut portions 41 and 41, the raised portion 46 being raised from the flange portion 42 so as to engage with the base section of the outer nozzle 38 and the two cut portions 41 and 41 being formed in the raised portion 46.

On the other hand, the outer nozzle part 45b includes the outer nozzle 38 in the form of a truncated cone with its inside rendered hollow, a flange portion 43 formed at the base section of the nozzle, and two projection portions 44 and 44 formed projecting inwardly from the inner periphery of the flange portion 43.

The outer nozzle part 45b is joined with the inner nozzle part 45a by aligning the two projection portions 44 and 44 of the flange portion 43 of the outer nozzle part with the corresponding cut portions 41 and 41 of the inner nozzle 45a. As the inner nozzle part 45a is joined with the outer nozzle part 45b, the inner nozzle 36 is covered as a whole with the outer nozzle 38, and the material

nozzle line 31 is defined as a space or clearance between the outer wall of the inner nozzle 36 and the inner wall of the outer nozzle 38. Therefore, the material nozzle line 31 is disposed about and enclosing the gas nozzle line 32.

5           The highly viscous material feed section 16 of Fig. 1 can be realized in a very simple configuration as shown in Fig. 5. In Fig. 5, the highly viscous material feed section 16 may comprise a storage can 47 for storing the highly viscous material, a pump 48 for discharging a given  
10 flow amount of the highly viscous material stored in the storage can 47, a valve 49 for opening and closing a path through which the highly viscous material stream discharged flows, a check valve 50 for preventing a return flow of the highly viscous material stream, and a tubular line 51  
15 connected to the material inlet 11a of the discharging device 10. The pump 48 may include, for example, a plunger pump of a floor plate type.

          It is to be noted herein that the highly viscous material to be stored in the storage can 47 may preferably  
20 include a highly viscous material selected from highly viscous materials that are fluid and flowable and have a low dynamic viscosity in a high speed flow region, on the one hand, and have a high static viscosity and has the high ability to retain the shape into which it is molded in a  
25 low speed flow region, on the other. Therefore, the pump 48 is arranged to select its discharging pressure so as to discharge the highly viscous material fed to the discharging device 10 at a high speed.

When it is desired that the hollow bead is tacky or adhered to a work 23 of a control board as in this embodiment, a highly viscous material having a tackiness or adhesive property is selected for a portion where they are to be tackied or adhered to the work 23 when cured, while a highly viscous material having no tackiness or adhesive property is selected for a portion where they are not to be tackied or adhered thereto. It is also possible to use a highly viscous material having no tackiness or adhesive property, however, when a applying position of the work 23 is pre-applied with an adhesive and then the highly viscous material is discharged onto the applying position thereof with the adhesive pre-applied thereon.

The gas feed section 14 of Fig. 1 may be showed the gas feed device 14, for example, as indicated in Fig. 6. The nitrogen gas feed device 14 may consist of an input port 140 through which compressed air is fed, an electromagnetic valve 142 capable of adjusting a flow rate of the compressive air to be fed on the basis of a pressure value measured by a manometer 144, a filter 148, a manometer 146 for measuring a pressure of nitrogen gas passing through the filter 148, a membrane module 150 capable of permeating nitrogen gas at a slower membrane permeability while discharging hydrogen, oxygen and other gases at a faster membrane permeability, a pressure reducing valve 151 for reducing a pressure value of the nitrogen gas permeated through the membrane module 150 on the basis of the pressure value measured by a manometer 152,

an oxygen sensor 153 for sensing oxygen O<sub>2</sub> from the gases permeated through the membrane module 150, a flow meter 154 for measuring a flow rate of the nitrogen gas, a needle valve 155 for controlling the discharging of the separated  
5 nitrogen gas, and a discharging port 156 for discharging the nitrogen gas. As described above, the nitrogen gas feed device 14 has a very simplified structure of a membrane separation type, so that nitrogen gas can readily be separated and generated from compressive air fed.

10 It is preferred to adjust the pressure of the gases to be fed from the gases feed section 14 to a pressure level somewhat higher than atmospheric pressure. Further, the gases feed section 14 may also include, for example, a system for feeding air or other gases as well as nitrogen  
15 gas.

Then, a description will be made regarding the action of the structure according to the first embodiment of the present invention with reference to the accompanying drawings.

20 The work 23 for control boards loaded on the belt 67 of the belt conveyor 65 at predetermined intervals are transferred one after another (e.g., in the direction perpendicular to the drawing paper plane of Fig. 1) into an area where the manipulator 60 can be moved. Before  
25 operating the step of discharging the highly viscous material, the discharging device 10 is located in a waiting position such that the tip of the rod 19 is engaged with the valve path 28 by the compressive air control of the



compressive air control section 18 and the highly viscous material fed from the highly viscous material feed section 16 is stored in the material chamber 27. On the other hand, the gas control valve 11c is closed so that the gases  
5 discharged from the gases feed section 14 are not yet fed to the discharging device 10.

As the detection sensor 25 detects that the work 23 is carried to the predetermined position, the operation of the belt conveyor 65 is temporarily stopped. Then, the  
10 controller 22 controls the manipulator 60 so as to transfer the discharging device 10 to the position right above the predetermined applying position of the work and direct the nozzle 12 downward directly to the predetermined applying position thereof. Thereafter, the compressive air control  
15 section 18 is controlled so as to release the rod 19 from the valve path 28 and to open the gas control valve 11c.

Once the gas control valve 11c is opened, the gases are discharged directly downward from the tip of the inner nozzle 36 through the inner gas path 30 and the gas nozzle  
20 line 32 by the aid of the feed pressure from the gases feed section 14, thereby forming gases stream flowing in the one direction. On the other hand, the highly viscous material within the material chamber 11a are also discharged directly downward from the tip of the outer nozzle 38  
25 through the inner material path 29 and the material nozzle line 31 enclosing the inner nozzle by the aid of the feed pressure from the highly viscous material feed section 16. This creates a flow of the highly viscous material stream

in a high speed flow region in substantially the same flow direction as the flow of the gas stream in an outer peripheral space about and enclosing the gases stream flowing in the one direction.

5           The controller 22 controls the manipulator 60 so as for the discharging device 10 to be movable on the plane (i.e., the plane parallel to the surfaces of the work 23) perpendicular to the discharging direction along a predetermined applying position 56 of the work 23 (e.g., a  
10   site nearby the entire circumference of an edge portion of the lid plate 23 as shown in Fig. 8(a)) in such a state that the discharging device 10 is discharging the gases and the highly viscous material from the nozzle 12.

          While the highly viscous material is being discharged  
15   directly downward to the predetermined applying position of the work 23 from the nozzle 12, the speed of the flow of the highly viscous material stream is in a high speed flow region by the aid of the feed pressure from the highly viscous material feed section, as shown in Fig. 7(a).

20   Therefore, the bead can be molded in a flexible manner by reducing a loss in pressure within the flow passage because of the low dynamic viscosity of the highly viscous material and by transferring the nozzle. However, as the flow of the highly viscous material stream has struck the top  
25   surface of the predetermined applying position of the work 23, for example, the flow speed of the highly viscous material stream in the high speed flow region is rapidly decreased to a low speed and eventually to zero. Therefore,

the static viscosity of the highly viscous material stream is caused to increase so high that the highly viscous material is allowed to stay in the shape on the predetermined applying position into which the material  
5 has been applied and molded in the low speed flow region, i.e., in the shape which it has held as it struck the predetermined applying position on the work 23. In other words, the highly viscous material stream holds the shape in a concentrically circular form with the gas stream, when  
10 looked in section, in such a manner that the highly viscous material stream is located outside about and enclosing the gas stream. Further, as the nozzle 12 is transferred along the applying position while maintaining this state, the highly viscous material is applied and molded into the  
15 given shape on the work 23 along the shape of the predetermined applying position thereof. In other words, the highly viscous material is set into the shape into which it is discharged on the predetermined applying position of the work 23.

20 When a highly viscous material of a cold-setting type is used, it is set continually as the time elapses while maintaining the shape as it has been applied. On the other hand, when a highly viscous material of a heat-setting type is used, a heating step of heating the highly viscous  
25 material applied has further to be added to the step of applying and molding the highly viscous material.

Fig. 7(b) shows a hollow bead applied and molded into a shape in the manner as described above. As shown in Fig.

7(b), a hollow bead 54 in tubular form is shown having a hollow portion 52 formed therein with a gas path left hollow and an outer peripheral portion 53 formed about and enclosing the hollow portion 52. The hollow bead 54 is  
5 molded by discharging the gases flowing stably through the central portion thereof and the highly viscous material flowing stably about and enclosing the outer periphery of the gas stream from the nozzle 12 of a double nozzle configuration. Therefore, the hollow bead applying and  
10 molding method according to the present invention can provide the hollow bead of high quality in a stable manner.

The hollow bead 54 can also be molded into the shape in section corresponding to the sectional shape of the nozzle 12 of the discharging device 10. As each of the  
15 inner nozzle 36 and the outer nozzle 38 in this embodiment is in the form of a concentric circle as shown in Fig. 3, the sectional shape of the bead 54 is likewise in the form of a concentric circle corresponding to the sectional shape of each of the nozzles 36 and 38. It is to be noted herein  
20 as a matter of course that the sectional shape of the bead 54 can be varied in optional and appropriate manner by optionally varying the sectional shape of each of the nozzles.

The controller 22 can control the manipulator 60 in  
25 the procedures as described above so as to apply and mold the hollow bead following and along the entire periphery of a applying position 56 (Fig. 8(a)). Upon molding and applying the bead, a CCD sensor 25 picks up an image of the

applied hollow bead, and the image data is always transmitted to the controller 22 through the I/O port 20. The controller 22 extracts an outline of the tip portion of the actually applied hollow bead by analyzing the received  
5 image data at a real time, and calculates the applying position at the current time. Then, the applying position as a target time pre-stored in the memory unit 24 is retrieved, and a deviation between the actual applying position calculated and the target applying position  
10 retrieved is calculated. Thereafter, the manipulator 60 is controlled in accordance with the predetermined control algorithm (e.g., PI control, etc.) so as to adjust the accurate discharging position of the nozzle 12 by adjusting this deviation to substantially zero.

15 Finally, as shown in Fig. 8(b), the hollow bead 57 is applied and molded accurately over the entire periphery close to the edge portion of the work 23. Furthermore, the discharging of the discharging device 10 is stopped and then the belt conveyor 65 is re-started ready for the next  
20 procedures and transfers another work 23 loaded next to the work 23 previously processed to the applying position. The like procedures are repeated until all the work 23 have been applied and molded.

In the method in this embodiment, it may be possible  
25 to automatically decide whether one work 23 has been applied and molded in a complete and favorable manner as it has been covered with the hollow bead 57. For instance, the CCD sensor 26 picks up an entire image of the hollow bead

57 applied thoroughly, and the image data is transmitted to the controller 22. The controller 22 detects an entire outline of the hollow bead 57 by analyzing the image data received, and a feature pattern is extracted. Then, a  
5 reference feature pattern of a hollow bead accurately applied, which has been pre-stored in the memory unit 24, is retrieved, and the feature pattern of the actually applied hollow bead is compared with the retrieved reference feature pattern of the hollow bead to determine a  
10 degree of similarity. If it is decided that the degree of similarity exceeds a predetermined value, then the hollow bead applied is determined as no good. On the other hand, if it is decided that the degree of similarity is below the predetermined value, the hollow bead applied is determined  
15 as good. These decision results may be displayed on a display unit or any other suitable unit (not shown). Therefore, the operator can take the necessary measures as soon as possible in accordance with the decision results displayed on the display unit, etc.

20 In the embodiment of the present invention, although the work 23 is curved at the corners thereof, the hollow bead 57 can be readily applied and molded at a curved portion, e.g., at the corners thereof, because the hollow bead 57 is made of the highly viscous material that is  
25 fluid and flows in a high speed flow region during applying. Moreover, the hollow bead 57 can maintain the configuration in which the gas stream is flowing at the central portion thereof and the highly viscous material stream is flowing

about and enclosing the gas stream, so that even a curved hollow bead by curved the high viscous material of high quality can also be molded with ease. Therefore, the hollow bead can readily be molded into any optional and  
5 suitable shape. In other words, in this embodiment, the hollow bead can readily be applied and molded into an irregular shape, while sustaining high quality, due to fluidity of the highly viscous material in a high speed flow region, flow stability, and ability of retaining the  
10 shape into which the bead is molded in a low speed flow region.

In addition, the hollow bead 57 can provide a sealing section with appropriate flexibility because it is lightweight and low in stress upon compression due to the  
15 hollow configuration within the bead. This presents the merits that sealing properties of an opening/closing member can be improved, for example, when the control board is closed with the lid 23 and that the operations for opening and closing the lid can be conducted with ease due to the  
20 lightweight material. This embodiment of the present invention can realize the hollow bead applying and molding system 1 having the above merits in simple structure as shown in Figs. 1 to 6.

#### Second Embodiment:

25 In the second embodiment, a foamed bead is used, in place of the hollow bead used in the first embodiment, and the foamed bead comprises a foamed body with the inside formed into a tubular shape and the outer periphery applied

with a highly viscous material. The same elements of the foamed bead in this embodiment are provided with the same numerical references and symbols as those in the first embodiment, and a duplicate description is omitted for  
5 brevity of explanation.

Fig. 9 shows an overall configuration of an automatically applying and molding system 2 in accordance with the second embodiment of the present invention. The automatically applying and molding system 2 in this  
10 embodiment is configured such that the gases feed section 14 used in the first embodiment is replaced with a foamable material feed section 14b that feeds a foamable material for forming a foamed body by foaming gases upon discharging.

In order to adapt this modification to discharging  
15 the foamable material, the discharging device 10 in the first embodiment may be modified to a discharging device 10b in the second embodiment. For instance, the discharging device 10b may include a feed inlet for feeding the foamable material and a control valve disposed in the  
20 feed inlet, and the inner configuration of the nozzle 12b, particularly a path of the inner nozzle or the like, is modified in a favorable fashion as a path for feeding the foamable material. However, the structure of the second embodiment is basically equal to that of the first  
25 embodiment, so that a detailed illustration of the discharging device 10b is omitted in the accompanying drawings.

When the foamable material is fed in the form of a



mixture of gases with the highly viscous material, the foamable material feed section 14b may be modified into the structure as shown in Fig. 10. The foamable material feed section 14b may include a gases feed unit 237A, a highly viscous material feed unit 237B, a mixing unit 237C, and a dispersing unit 237D.

The gases feed unit 237A feeds gases at pressure in a predetermined range as low as from approximately 0.1 to 5 Kg/cm<sup>3</sup>, preferably from approximately 0.1 to 3 Kg/cm<sup>3</sup>. In this embodiment, a nitrogen gas generator of a known configuration may be used, which is arranged to separate nitrogen gas from compressed air by a membrane separation system. The gases feed unit 237A may comprise, for example, a port 231 for receiving compressed air from a compressor (not shown), a filter 232, a membrane separation module 233, a pressure regulating valve 234, a gas flow meter 235, and a tubular path 239A for feeding separated nitrogen gas.

The highly viscous material feed unit 237B may comprise a plunger pump 242A for discharging the highly viscous material stored in the storage can at a constant flow amount, a motor 230 for driving the pump 242A, and a tubular path 239B through which the discharged highly viscous material flows.

The mixing unit 237C may include two piston pumps 245A and 245B, each of which conducts the suction stroke and the extrusion stroke by reciprocally moving the piston in the cylinder. The piston rod of each of the piston pumps 245A and 245B is connected to motors 236A and 236B,

respectively, which reciprocally drive the pistons in a linear way.

The tubular path 239A of the gases feed unit 237A is branched into two tubular path branches, one tubular path  
5 branch being connected to the position close to the top dead center of the piston pump 245A through a control valve V1 and the other tubular path branch being connected to the position close to the top dead center of the piston pump 245B through a control valve V2. Further, the tubular path  
10 239B of the gases feed unit 237B is branched into two tubular path branches, one tubular path branch being connected to the position close to the bottom dead center of the piston pump 245A through a control valve V3 and the other tubular path branch being connected to the position  
15 close to the bottom dead center of the piston pump 245B through a control valve V4. In other words, the piston pumps 245A and 245B are configured to introduce the highly viscous material fed from the highly viscous material feed unit 237B and the gases fed from the gases feed unit 237A,  
20 respectively, at a predetermined rate in a batch manner. It is to be understood herein that the term "bottom dead center" of the piston pump referred to herein means the stroke end section of the extrusion stroke and the term "top dead center" of the piston pump referred to herein  
25 means the stroke end section of the suction stroke.

Furthermore, the piston pumps 245A and 245B are each provided with a discharging tubular path for discharging a mixture obtainable by mixing gases with the highly viscous

material in the cylinder, which extends from the stroke end  
section of the extrusion stroke. The discharging tubular  
paths are further provided with valves V5 and V6 as well as  
check valves CV5 and CV6, respectively, and they are then  
5 united into a tubular path 239C.

The operations of the piston pumps 245A and 245B of  
the mixing unit 237C and the valve system are controlled in  
accordance with a timing chart as shown in Fig. 11. It is  
to be noted herein that the piston pumps 245A and 245B are  
10 operated such that the extrusion stroke of each piston pump  
does not overlap with each other. As indicated in the  
timing chart of Fig. 11, the gases are introduced into the  
cylinder by the suction stroke, and the highly viscous  
material under a high pressure is allowed to be fed while  
15 the piston is positioned at the stroke end section of the  
suction stroke. Then, a mixture of the gases with the  
highly viscous material is discharged by the extrusion  
stroke. In this case, the gases are compressed by the  
highly pressurized highly viscous material subsequently  
20 filled therein to the volume that can be regarded as  
negligible, so that the highly viscous material can be  
mixed with the gases in the amount substantially equal to  
the cylinder volume. This can readily lower the pressure  
of the gases to be fed into the cylinder and control a  
25 mixing ratio of the gases to the highly viscous material by  
adjusting the pressure of the gases to be fed.

The tubular path 239C is connected to a discharging  
tubular path 244 through the dispersing unit 237D that in

turn may include a pressurizing device 241 composed of a piston pump, etc. and a dispersing tubular path 243. The pressurizing device 241 then pressurizes the mixture fed while flowing through the tubular path 239C, and the  
5 mixture under pressure is introduced into the dispersing tubular path 243. While the mixture is passing through the dispersing tubular path 243, gaseous bubbles are dispersed in more minute form in the highly viscous material. Then, the minutely dispersed gaseous bubbles are expanded as the  
10 mixture is released into atmospheric pressure upon discharging, thereby forming a foamed body.

Then, the action of the second embodiment of the present invention will be described. A description will be given regarding the action part only, which is different  
15 from the action of the first embodiment, and a description of the equal and like action part of the first embodiment will be omitted from the following explanation.

In the second embodiment, the discharging device 10b is disposed so as to move along the applying position of  
20 the work 23 while discharging the highly viscous material from the outer nozzle 38, on the one hand, and the foamable material in the form of a mixture of gases with the highly viscous material from the inner nozzle 36, on the other, toward the applying position thereof. At this time, a flow  
25 of the foamable material stream in the one direction is formed, while a flow of the highly viscous material in a high speed flow region in the same direction is formed within an outer peripheral space outside and about the

foamable material stream. As the highly viscous material stream is discharged about and enclosing the foamable material stream and reaches the applying position of the work 23, the high speed flow of the highly viscous material stream is dropped to the low speed flow and eventually zero and the highly viscous material stream is applied on the applying position of the work 23 and molded into the shape corresponding to the shape of the applying position thereof. On the other hand, the foamable material stream is discharged and allowed to foam into a foamed body upon exposure to atmosphere. The foamed body is filled in the inside of the highly viscous material while sustaining its shape, and molded into the shape corresponding to the shape of the inner wall made of the highly viscous material. Then, the highly viscous material and the foamed body are allowed to cure, while sustaining the shape as it was before curing.

In the second embodiment, there is obtained the foamed tubular bead with the inside filled with the foamed body and with the outside composed of and covered with the highly viscous material (as shown in Fig. 7(b), however, the hollow portion 52 of the hollow bead 54 being replaced with the foamed body).

As the foamed bead is also a foamed body with the inside rich with gases bubbles, it is lightweight and requires a small amount of stress upon compression, thereby providing a sealing section having an appropriate degree of flexibility and softness. Therefore, the foamed bead can

present the benefits that it provides the lid 23 of a control board with improved sealing performance when closed and that operations of opening and closing the lid 23 are conducted with ease particularly due to its light weight.

5           Moreover, the foamed bead according to this embodiment can provide with the resulting foamed body with improved waterproof performance, airtight performance, shock absorbing performance, and so on, as compared with a bead of a foamed body covered with no highly viscous  
10 material.

#### Third Embodiment:

The third embodiment is directed to a bead molding apparatus capable of manually applying and molding a hollow bead or a foamed bead on a desired site, rather than an  
15 automatically applying system suitable for a large-scale production in accordance with the above embodiments.

Fig. 12 shows a bead molding apparatus according to the third embodiment. The same and like elements are provided with the same reference numerals and symbols as  
20 those in the first and second embodiments, and a duplicate description of the same and like elements will be omitted for brevity of explanation.

The discharging device 10c of Fig. 12 is substantially equal in structure to the discharging device  
25 10 of the first embodiment and the discharging device 10b of the second embodiment. In this embodiment, the discharging device 10c is arranged in such a manner that the gas or the foamable material is discharged from the

inner nozzle and the highly viscous material is discharged from the outer nozzle, thereby applying and molding the hollow bead or the foamed bead. The discharging device 10c has a grip portion 167 with a discharging switch 167 and  
5 can control the opening and closing of a control valve disposed in a path for feeding the gas or the foamable material and a control valve disposed in a path for feeding the highly viscous material by turning the discharging switch 167 on or off.

10 As shown in Fig. 12, a bead molding device 160 is disposed on a carrier 161 with a caster 162, and comprises a feed device 163 for feeding each of gases or the foamed material and the highly viscous material, a mounting seat 164 disposed extending from the side of a housing of the  
15 feed device 163, the discharging device 10c disposed detachably on the mounting seat 164 through the grip portion 167, and a bundle of hoses 168 connecting the discharging device 10c to the feed device 163.

The bead molding device 160 allows the operator to  
20 apply a desired site with the hollow bead or the foamed bead.

As have been described above, the present invention has been explained by way of the embodiments. It is to be noted herein, however, that the present invention is not  
25 limited in any respect to those embodiments and that any modifications or variations are encompassed without departing from the scope and spirit of the present invention.

Although the hollow tubular bead covered with the highly viscous material is molded in the first embodiment, the present invention can be extended to a system for molding the hollow bead covered with a tubular foamed body.

5 This extension can be readily realized by replacing the highly viscous material feed unit 16 of the bead applying and molding system 1 of Fig. 1 with the highly viscous material feed unit of Fig. 10.

10 In the above embodiments, controlling the speed of the flow of the highly viscous material stream or the foamable material stream varies the fluidity of the highly viscous material stream or the foamable material stream. It is also possible to use a hot melt material and a foamable hot melt material, the hot melt material being  
15 fluid when it is in the form of a stream in a middle-high temperature region and high in the ability to retain the shape into which it is molded when it is in the form of a stream in a middle-low temperature region, and the foamable hot melt material being obtainable by foaming such a hot  
20 melt material. When the hot melt material is used, it is heated before applying to increase its fluidity and to increase the ability to retain the shape into which the material is allowed to cool immediately before applying or after applying.

25 Further, in the first and second embodiments, the lid for the control board is used as an object to be applied and molded. It is to be noted herein that the present invention is not limited to this object and can be applied



to, for example, an opening and closing member for closing  
an arbitrary opening portion, e.g., a window glass, plastic  
glass, plastic plate, metallic door, or any other  
appropriate object, and to a site requiring waterproof,  
5 airtight, and shock-absorbing performance, e.g., an  
engagement section, a clearance section, and so on.

Moreover, in the above embodiments, the bead is  
applied over the entire periphery of the opening and  
closing member. The present invention is not limited to  
10 this way of applying and it may encompass the case within  
the scope of the invention, which is directed to applying  
the bead partially on a portion alone, when only the  
portion of the periphery of an opening and closing member  
is attached to an opening portion. In other words, the  
15 present invention can vary the applying position in an  
appropriate and optional way in accordance with the object,  
i.e.. an opening and closing object, etc.

Furthermore, the present invention is not limited to  
the specific method for applying and attaching the bead to  
20 a predetermined applying object, as described above, and it  
can be applied to the case where the hollow bead or the  
foamed bead is molded using a highly viscous material of a  
non-adhesive property. For instance, it is also possible  
to prepare a product made of a bead only which is not  
25 tackied to any member by molding an elongated bead while  
winding the discharged and molded bead on a rotary roller  
or the like and cutting to a desired length after  
separating the molded bead from the roller.

In addition, in the second embodiment, the mixture of the gases with the highly viscous material is used as the foamable material. The present invention, however, is not limited to the use of the mixture and it may be applied to  
5 the use of a highly viscous material of a heat-foamable type or a two-liquid foamable material, for example.

Further, in the above embodiments, there is used the mixture feed device 50 with the cylinder pump as a system for mixing the gases with the highly viscous material. The  
10 present invention, however, is not limited to this particular mixing system and may include, for example, a stirring-mixing unit such as a mixer and so on.

## CLAIMS

1. A bead molding method for molding a hollow bead from a highly viscous material that is fluid in the form of a stream in a high speed flow region and can retain a shape into which it is molded in a low speed flow region; comprising:

a gas stream forming step for forming a gas stream in a one direction;

a material stream forming step for forming a highly viscous material stream flowing in the high speed flow region within an outer peripheral space about and enclosing the gas stream; and

a bead molding step for molding the hollow bead into an irregular shape by reducing the flow speed of the highly viscous material stream from the high speed flow to the low speed flow while rendering the highly viscous material stream fluid within the outer peripheral space about and enclosing the gas stream.

2. A bead molding method for molding a hollow bead from a foamable material for forming a foamed body, comprising:

a gas stream forming step for forming a gas stream in a one direction;

a material stream forming step for forming a foamable material stream flowing in the same direction as the gas stream within an outer peripheral space about and enclosing the gas stream; and

a bead molding step for molding the hollow bead into an irregular shape by reducing the flow speed of the

foamable material stream from the high speed flow to the low speed flow while fluidizing the foamable material stream flowing within the outer peripheral space about and enclosing the gas stream.

3. The bead molding method as claimed in claim 1 or 2, wherein the bead molding step molds the hollow bead into a shapes corresponding to and following the shape of the applying position by applying the work with the hollow bead or the foamable material onto the applying position while transferring the streams along the applying position.

4. The bead molding method as claimed in claim 3, wherein the hollow bead applied and molded are tackied or adhesived to the work by using the highly viscous material or the foamable material has an tackinessly or adhesive property.

5. The bead molding method as claimed in any one of claims 1 to 4, further comprising a discharging device including an inner nozzle elongated at a tip portion thereof and an outer nozzle elongated about and enclosing an outer periphery of the inner nozzle; wherein:

the gas stream forming step forms the gas stream in the one direction by discharging gases from the inner nozzle; and

the material stream forming step forms the highly viscous material stream or the foamable material stream in the same direction of the gas stream about and enclosing the gas stream by discharging the highly viscous material or the foamable material from the outer nozzle.

6. The bead molding method as claimed in claim 3 or 4, wherein there is disposed a discharging device including an inner nozzle elongated at a tip portion thereof and an outer nozzle elongated about and enclosing an outer periphery of the inner nozzle;

the gas stream forming step forms the gas stream in the one direction by discharging the gases from the inner nozzle;

the material stream forming step forms a stream of the highly viscous material or the foamable material in the same direction of the gas stream about and enclosing the gas stream by discharging the highly viscous material or the foamable material from the outer nozzle; and

the bead molding step molds a hollow bead into a shape corresponding to and following the shape of the applying position by discharging the highly viscous material stream or the foamable material stream toward the work from the inner nozzle and the outer nozzle in the outer peripheral space of the gas stream while transferring the nozzles in a locus corresponding to and following the shape of the applying position.

7. A bead molding method for molding a foamed bead into a given shape, composed of a foamed body covered with a highly viscous material that is fluid in the form of a stream in a high speed flow region and retains the shape into which it is molded in a low speed flow region, comprising:

a foamable material stream forming step for forming a

stream of a foamable material for forming the foamed body in a one direction;

a material stream forming step for forming a stream of the highly viscous material in the high speed flow region in an outer peripheral space enclosing and about the foamable material stream; and

a foamed bead molding step for molding the foamed bead into an irregular shape by foaming the foamable material while fluidizing the highly viscous material flowing in the outer peripheral space of the foamable material stream and reducing the high speed flow of the foamable material stream to the low speed flow thereof.

8. The bead molding method as claimed in claim 7, wherein the foamed bead molding step molds the foamed bead into the given shape by following the shape of the applying position while transferring the foamable material stream and the highly viscous material stream along the shape of the applying position while applying the work with the foamable material and the highly viscous material.

9. The bead molding method as claimed in claim 8, wherein the highly viscous material has an tackiness or adhesive property and the foamed bead applied and molded are tackied or adhesived to the work.

10. The bead molding method as claimed in any one of claims 7 to 9, wherein:

there is disposed a discharging device including an inner nozzle elongated at its tip and an outer nozzle elongated about and enclosing an outer periphery of the

inner nozzle;

the foamable material stream forming step forms the foamable material stream in the one direction by discharging the foamable material stream from the inner nozzle; and

the material stream forming step forms the highly viscous material stream in the same direction of the foamable material stream and about and enclosing the foamable material stream by discharging the highly viscous material stream from the outer nozzle.

11. The bead molding method as claimed in claim 8 or 9, wherein:

there is disposed a discharging device including an inner nozzle elongated at its tip and an outer nozzle elongated about and enclosing an outer periphery of the inner nozzle;

the foamable material stream forming step forms the foamable material stream in the one direction by discharging the foamable material stream from the inner nozzle;

the material stream forming step forms the highly viscous material stream in the same direction of the foamable material stream by discharging the highly viscous material stream from the outer nozzle; and

the bead molding step molds the foamed bead in a given shape following the shape of the applying position while transferring the inner nozzle and the outer nozzle along a predetermined locus following the work by

discharging the foamable material stream and the highly viscous material stream onto the applying position from the inner nozzle and the outer nozzle, respectively.

12. The bead molding method as claimed in claim 6 or 11, wherein:

the discharging device is mounted on a manipulator disposed to be transferable to a desired position in response to a control signal; and

the bead molding step for applying and molding the hollow bead or the foamed bead automatically on the applying position of a plurality of work members being carried one after another on a manufacturing line by controlling a movement of the discharging device by means of the manipulator.

13. The bead molding method as claimed in claim 12, wherein an actual applying position of the bead applied by the discharging device is detected and the manipulator is controlled so as to substantially bring the actual applying position thereof into agreement with a predetermined target applying position.

14. The bead molding method as claimed in claim 12 or 13, wherein it is decided to automatically determine whether the bead is applied and molded in a favorable fashion by desired picking up an image of the bead applied and molded on the applying position and comparing the picked-up image of the bead with a reference image of a bead applied and molded in a predetermined favorable fashion.

15. The bead molding method as claimed in any one of



claims 12 to 14, wherein the work member comprises an opening and closing member for closing a predetermined opening thereof.

16. The bead molding method as claimed in claim 15, wherein the applying position comprises a site disposed along and nearby an edge portion of the opening and closing member, and the hollow bead or the foamed bead applied and molded on the applying position forms a sealing section that seals a gap between the opening and the opening and closing member.

17. A bead molding apparatus for molding a hollow bead comprising:

a discharging device including an inner nozzle disposed extending at a tip portion, an outer nozzle disposed extending about and enclosing an outer periphery of the inner nozzle, a first inlet connecting with the inner nozzle, and a second inlet connecting with the outer nozzle;

a gases feed unit for feeding gases to the discharging device through the first inlet; and

a material feed unit for feeding a highly viscous material or a foamable material to the discharging device through the second inlet, the highly viscous material being fluid in the form of a stream in a high speed flow region and capable of retaining a shape into which it is molded in a low speed flow region.

18. A bead molding apparatus for molding foamed bead comprising:

a discharging device including an inner nozzle disposed extending at a tip portion, an outer nozzle disposed extending about and enclosing an outer periphery of the inner nozzle, a first inlet connecting with the inner nozzle, and a second inlet connecting with the outer nozzle;

a foamable material feed unit for feeding a foamable material to the discharging device through the first inlet; and

a material feed unit for feeding a highly viscous material to the discharging device through the second inlet, the highly viscous material being fluid in the form of a stream in a high speed flow region and capable of retaining a shape into which it is molded in a low speed flow region.

19. The bead molding apparatus as claimed in claim 18, wherein the foamable material feed unit feeds a mixture of the gases with the highly viscous material as the foamable material.

20. The bead molding apparatus as claimed in claim 19, wherein the foamable material feed unit comprises:

a plurality of piston pumps arranged so as to perform an suction stroke and a extrusion stroke by reciprocally moving a piston in a cylinder;

a gases injection unit for supplying gases under a predetermined pressure into the cylinder; and

a formable material supplying unit for a pump control unit for controlling the plurality of the piston pumps in such a manner that each of the plurality of the piston

pumps is arranged to conduct the suction stroke for feeding gases and with the highly viscous material after the suction stroke and to conduct the extrusion stroke for discharging the mixture of the gases with the highly viscous material as the foamable material as well as that a time difference is provided for the extrusion stroke of each of the plurality of the piston pumps so as to continually discharge a predetermined quantity of the foamable material.

21. The bead molding apparatus as claimed in claim 20, wherein the foamable material feed unit further comprises a tubular path for dispersing minute bubbles of gases disposed in a discharge path of each piston pump.

22. The bead molding apparatus as claimed in any one of claims 17 to 21, wherein the discharging device is arranged so as for each of the inner nozzle and the outer nozzle to change an inner dimension of its inner wall into a smaller size over a region extending from an end portion of connection with a body of the discharging device to a tip portion thereof having a defined inner dimension.

23. The bead molding apparatus as claimed in any one of claims 17 to 22, wherein an outer wall portion of each of the inner nozzle and the outer nozzle containing an edge section at the top thereof has an inclining surface joining at an acute angle to the direction of the flow of the highly viscous material stream or the foamable material stream.

24. The bead molding apparatus as claimed in any one of

claims 17 to 23, wherein the inner nozzle and the outer nozzle are provided, respectively, with a first control valve for controlling the opening and closing of a path reaching the inner nozzle from the first inlet and a second control valve for controlling the opening and closing of a path reaching the outer nozzle from the second inlet.

25. The bead molding apparatus as claimed in claim 24, wherein the discharging device is capable of being hand-carried; and each of the first control valve and the second control valve is capable of being opened and closed by a manual on-off operation.

26. The bead molding apparatus as claimed in claim 24, wherein each of the first control valve and the second control valve is capable of being opened and closed automatically in response to an control signal.

27. The bead molding apparatus as claimed in claim 26, further comprising:

a manipulator mounted on the discharging device at a top portion thereof and disposed so as to be movable to a desired position in response to a control signal; and

a control unit for automatically controlling the movement of the manipulator and the discharging of the discharging device in accordance with a predetermined program.

28. The bead molding apparatus as claimed in claim 27, wherein the control unit automatically controls the movement of the manipulator and the discharge of the discharging device so as to automatically apply and mold

the hollow bead or the foamed bead on a applying position of each of a plurality of work being carried on a manufacturing line one after another.

29. The bead molding apparatus as claimed in claim 28, further comprising a detection unit for detecting an actual applying position of work the bead by the discharging device;

wherein the control unit controls the manipulator so as to bring the actual applying position detected thereby substantially into agreement with a predetermined target applying position of work.

30. The bead molding apparatus as claimed in claim 29, further comprising an image pick-up unit for picking up an image of the bead applied and molded on the applying position,

wherein the control unit automatically decides to determine whether the bead is applied and applied thereon in a favorable fashion by comparing the image of the bead picked-up by the image pick-up unit with a pre-stored reference image of the bead applied and molded in a favorable fashion.

31. A bead molding method for molding a hollow bead from a hot melt material that is fluid in the form of a stream in a middle-high temperature region and can retain a shape into which the hollow bead are molded in a middle-low temperature region;

a gas stream forming step for forming a gas stream flowing in a one direction;

a material stream forming step for forming a hot melt material stream in the middle-high temperature region within an outer peripheral space about and outside so as to enclose the gas stream; and

a bead molding step for molding the hollow bead into an irregular shape by lowering the middle-high temperature of the hot melt material to the middle-low temperature while fluidizing the hot melt material flowing in the outer peripheral space about the gas stream.

32. A bead molding method for molding a hollow bead from a foamable hot melt material for forming a foamed body, comprising:

a gases stream forming step for forming a gas stream in a one direction;

a material stream forming step for forming a stream of the foamable hot melt material in the direction identical to the direction of the gas stream within an outer peripheral space about and enclosing the flow of the gas stream; and

a bead molding step for molding the hollow bead into an irregular shape by foaming the foamable hot melt material flowing within the outer peripheral space of the gas stream.

33. The bead molding method as claimed in claim 31 or 32, wherein the bead molding step molds the hollow bead into a shape corresponding to and following the shape of a applying position by transferring the hot melt material stream or the foamable hot melt material stream along the

applying position while applying the work with the hot melt material or the foamable hot melt material.

34. The bead molding method as claimed in claim 33, wherein:

there is disposed a discharging device including an inner nozzle elongated at a tip portion thereof and an outer nozzle elongated about and enclosing an outer periphery of the inner nozzle;

the gases stream forming step forms the gas stream in a one direction by discharging gases from the inner nozzle;

the material stream forming step forms the hot melt material stream or the foamable hot melt material stream in the same direction as the gas stream by discharging the hot melt material or the foamable hot melt material from the outer nozzle; and

the bead molding step forms the hollow bead into the shape corresponding to and following the shape of the applying position by transferring the hot melt material stream or the foamable hot melt material stream along a predetermined locus while discharging the gas stream from the inner nozzle and the material stream from the outer nozzle toward the work.

35. A bead molding method for molding a foamed bead comprised of a foamed body covered with a hot melt material that is fluid in the form of a stream in a middle-high temperature region and can retain the shape into which it is molded in a middle-low temperature region; comprising:

a foamable stream forming step for forming a stream

of a foamable hot melt material for forming the foamed body;

a material stream forming step for forming a stream of the hot melt material flowing in the middle-high temperature region within an outer peripheral space the foamable hot melt material stream about and enclosing the foamable hot melt material stream; and

a bead-molding step for molding the foamed bead into an irregular shape by reducing the middle-high temperature region to the middle-low temperature region while fluidizing the hot melt material stream flowing within the outer peripheral side outside and about the foamable hot melt material stream.

36. The bead molding method as claimed in claim 35, wherein the bead-molding step molds the foamed bead into a shape corresponding to and following the shape of the applying position by transferring the foamable hot melt material stream and the hot melt material stream along the applying position while applying the work with the foamable hot melt material and the hot melt material.

37. The bead molding method as claimed in claim 35 or 36, wherein:

there is disposed a discharging device including an inner nozzle elongated at a tip portion thereof and an outer nozzle elongated enclosing an outer periphery of the inner nozzle;

the foamable material stream forming step forms the foamable hot melt material stream in the one direction by



discharging the foamable hot melt material from the inner nozzle; and

the material stream forming step forms the hot melt material stream in the direction equal to the direction of the foamable hot melt material stream and enclosing the foamable hot melt material by discharging the hot melt material from the outer nozzle.

38. The bead molding method as claimed in claim 36, wherein:

there is disposed a discharging device including an inner nozzle elongated at a tip portion thereof and an outer nozzle elongated enclosing an outer periphery of the inner nozzle;

the foamable material stream forming step forms the foamable hot melt material stream in the one direction by discharging the foamable hot melt material from the inner nozzle;

the material stream forming step forms the hot melt material stream in the same direction as the direction of the foamable hot melt material stream and enclosing the formable not melt material by discharging the hot melt material from the outer nozzle; and

the bead molding step for molding a foamed bead into a shape corresponding to and following the shape of the applying position by transferring the material stream along a given position while discharging the foamable hot melt material and the hot melt material from the inner nozzle and the outer nozzle, respectively.

39. The bead molding method as claimed in claim 37 or 38, wherein:

the discharging device is mounted on a manipulator disposed to be movable to a desired position in response to a control signal; and

the bead molding step applies and molds the hollow bead or the foamed bead automatically on the applying position of a plurality of work members being carried on a manufacturing line one after another by controlling the movement of the discharging device by means of the manipulator.

40. A bead forming apparatus for forming a hollow bead comprising:

a discharging device including an inner nozzle elongated at a tip portion thereof, an outer nozzle elongated about and enclosing an outer periphery of the inner nozzle, a first inlet connecting with the inner nozzle, and a second inlet connecting with the outer nozzle;

a gases feed unit for feeding gases to the discharging device through the first inlet; and

a material feed unit for feeding a hot melt material or a foamable hot melt material to the discharging device through the second inlet, the hot melt material being fluid in the form of a stream in a middle-high temperature region and can retain the shape into which the material is molded in a middle-low temperature region.

41. A bead forming apparatus for forming a foamed bead

comprising:

a discharging device including an inner nozzle elongated at a tip portion thereof, an outer nozzle elongated about and enclosing an outer periphery of the inner nozzle, a first inlet connecting with the inner nozzle, and a second inlet connecting with the outer nozzle;

a first material feed unit for feeding a foamable hot melt material to the discharging device through the first inlet; and

a second material feed unit for feeding a hot melt material to the discharging device through the second inlet, the hot melt material being fluid in the form of a stream in a middle-high temperature region and can retain the shape into which the material is molded in a middle-low temperature region.

42. The bead molding apparatus as claimed in claim 41, wherein the first material feed unit feeds a mixture of the gases with the hot melt material as the foamable hot melt material.

## ABSTRACT

The hollow bead of high quality are applied and molded into a shape corresponding to and following the shape of a applying position onto which the bead are to be applied. The bead-molding apparatus includes a discharging device 10 of a double nozzle structure 12 comprised of an inner nozzle 36 and an outer nozzle 38, a highly viscous material feed unit 16 for feeding a highly viscous material that is fluid in the form of a stream in a high speed flow region and can retain the shape into which it is applied and molded in a low speed flow region, a manipulator 60 disposed so as to transfer the discharging device 10 mounted thereon to a desired position, and a controller 22 for controlling the overall operations of the apparatus.

15 The discharging device 10 is controlled so as to move along the applying position of a work 23 while feeding gases thereto from the inner nozzle 36 and discharging the highly viscous material thereto from the outer nozzle 38.

Fig. 1

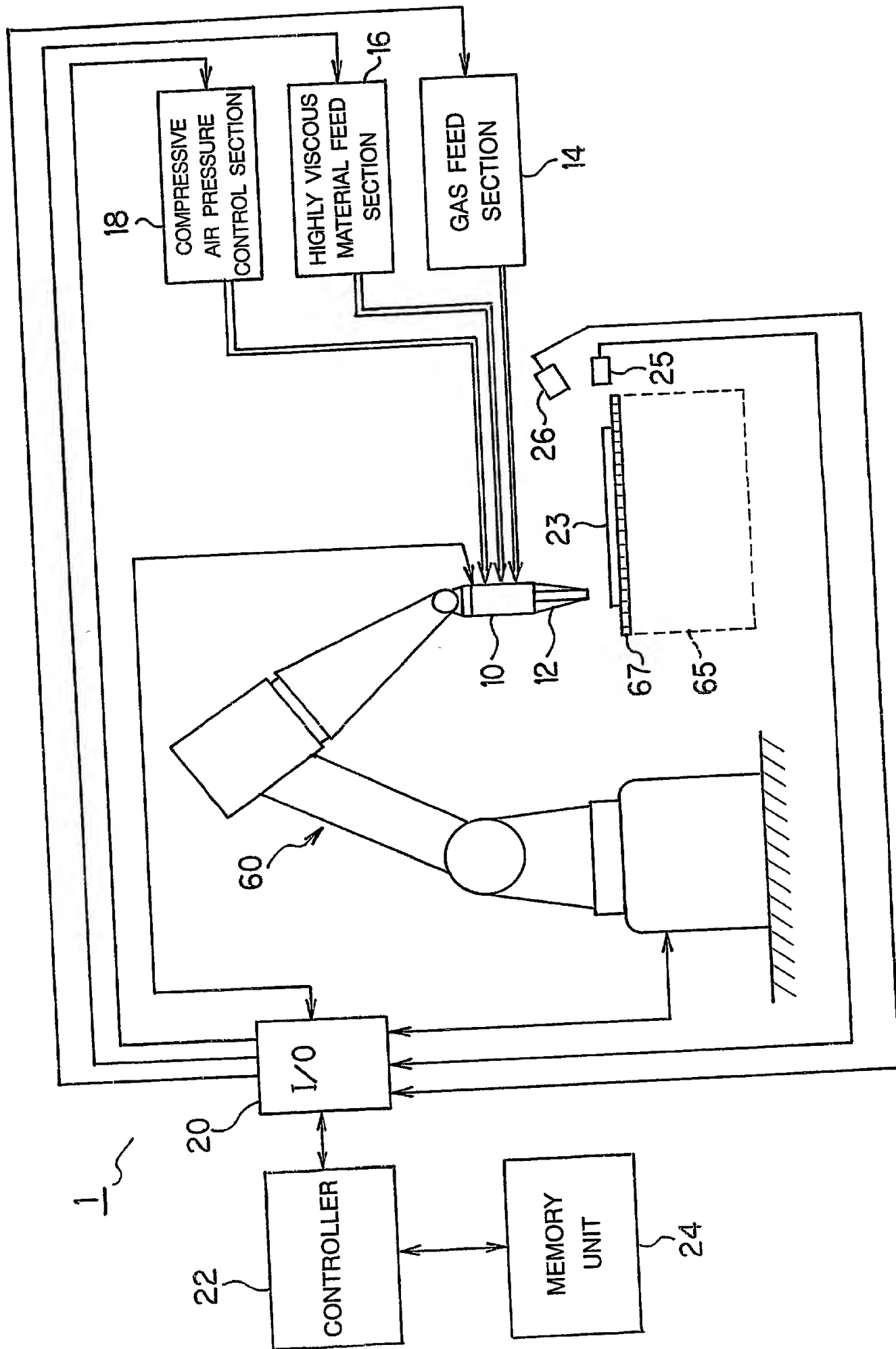


Fig. 2

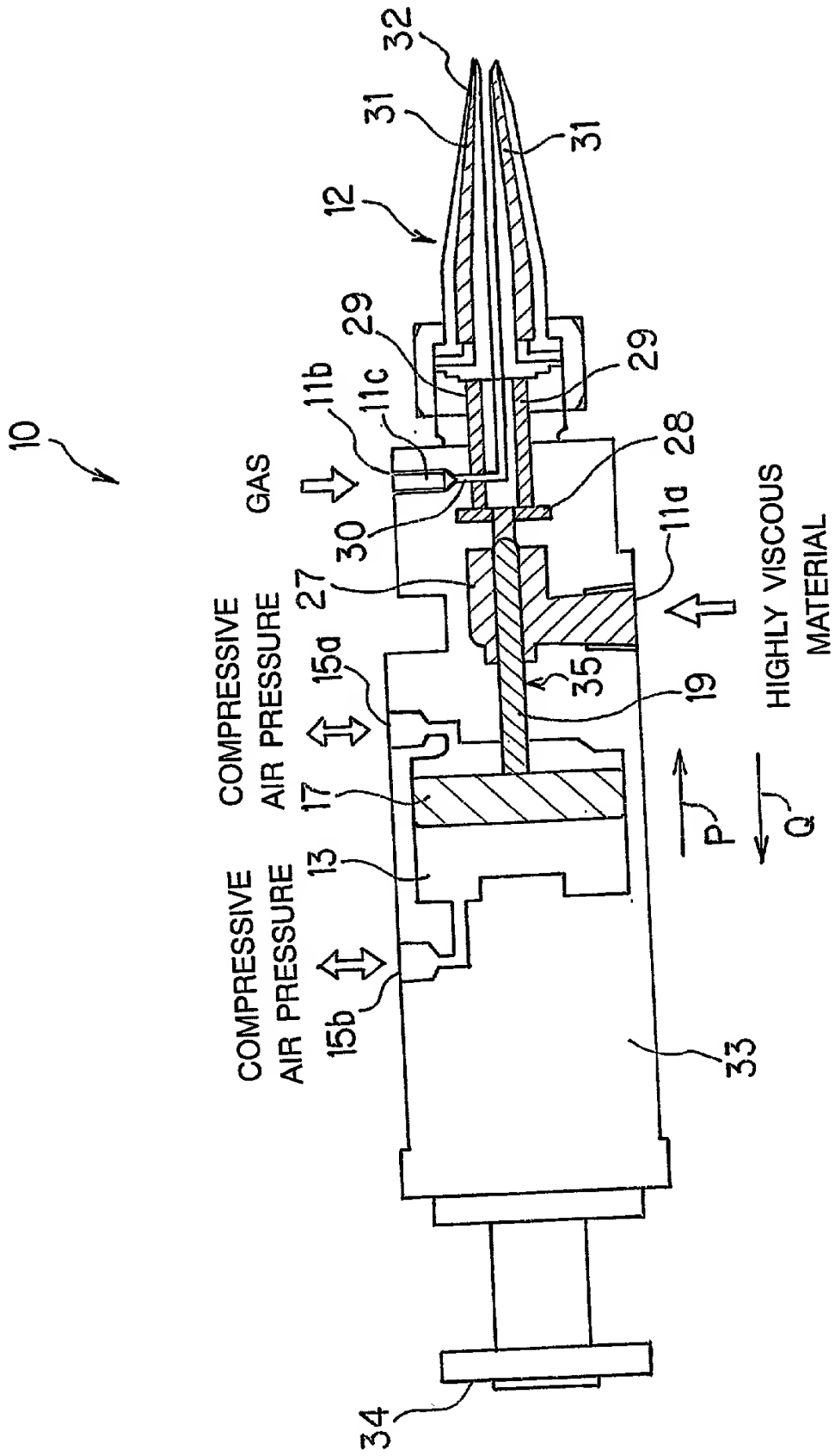
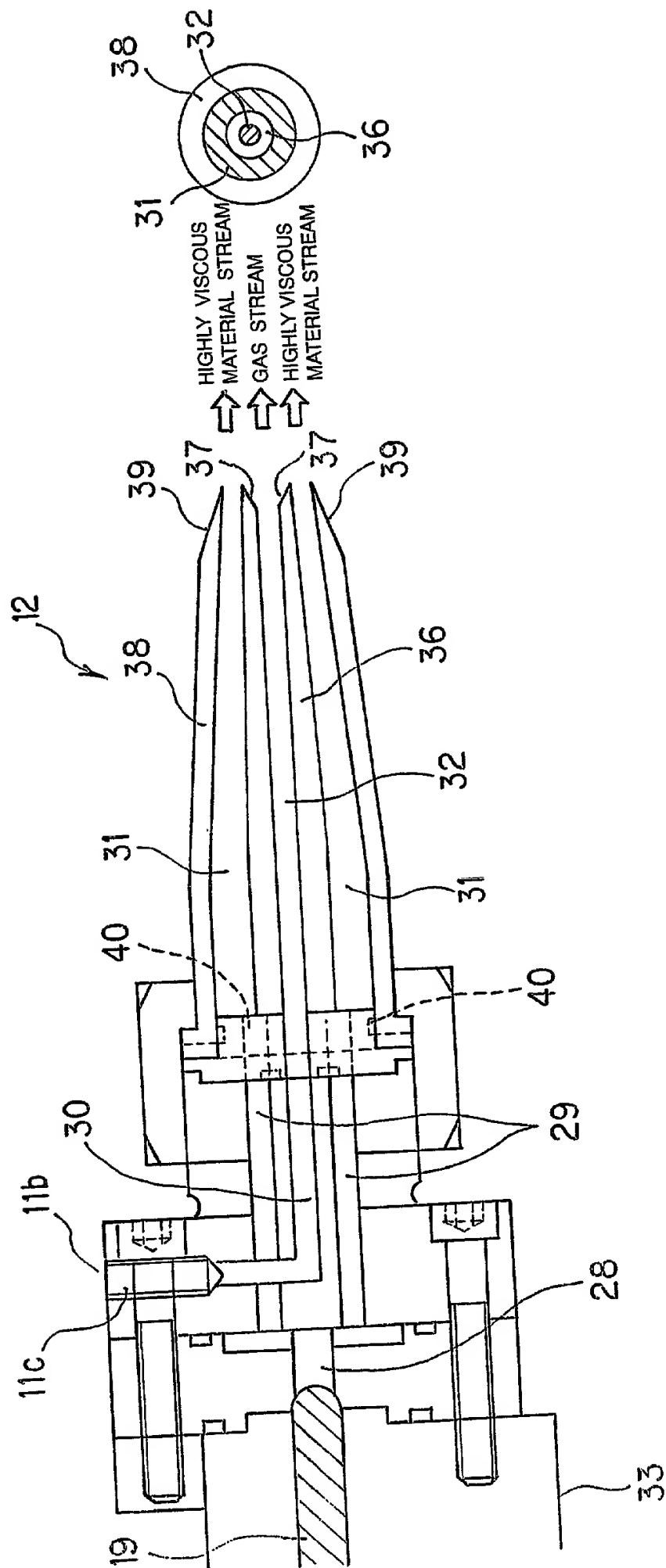


Fig. 3



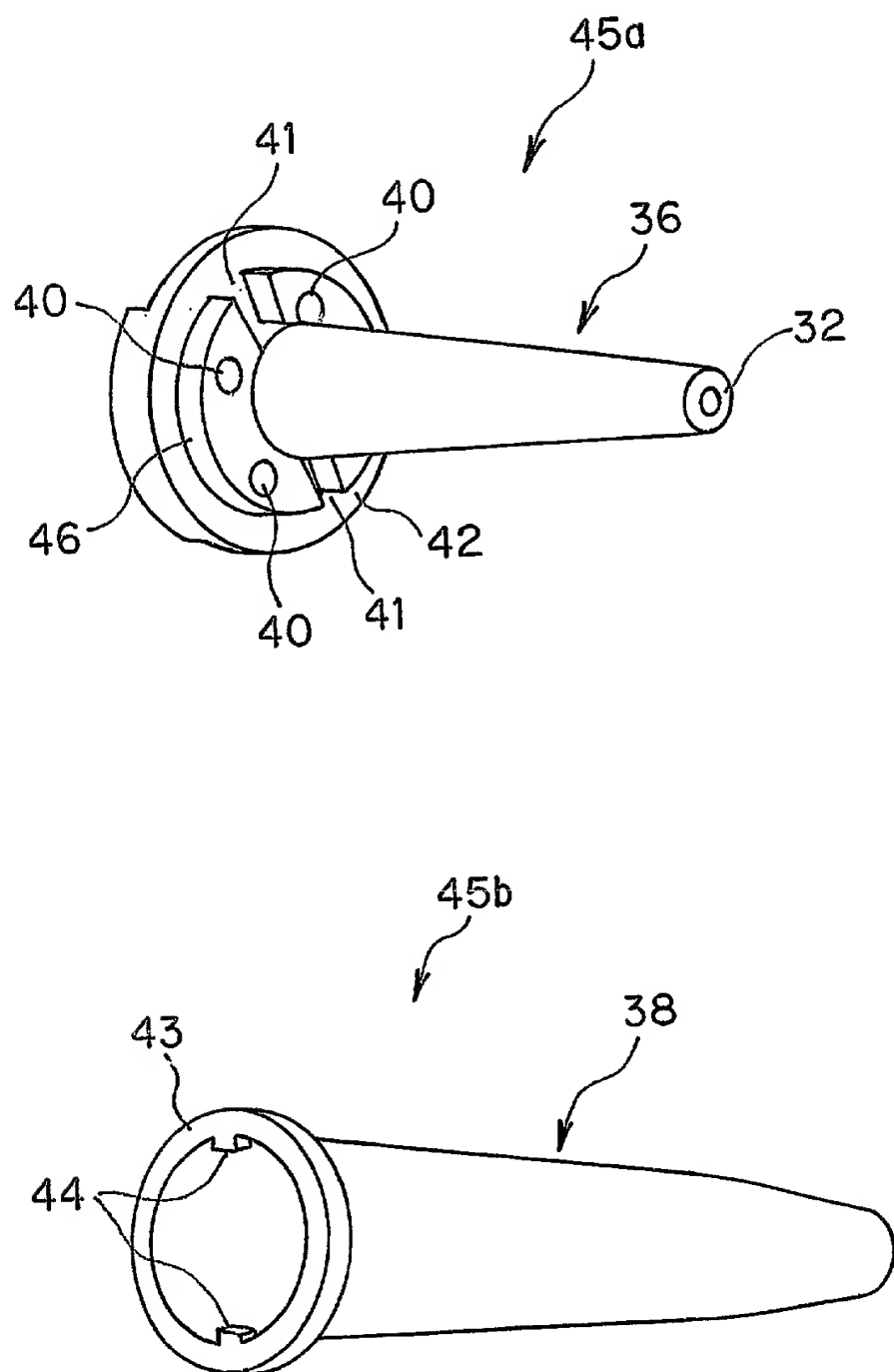
*Fig. 4*



Fig. 5

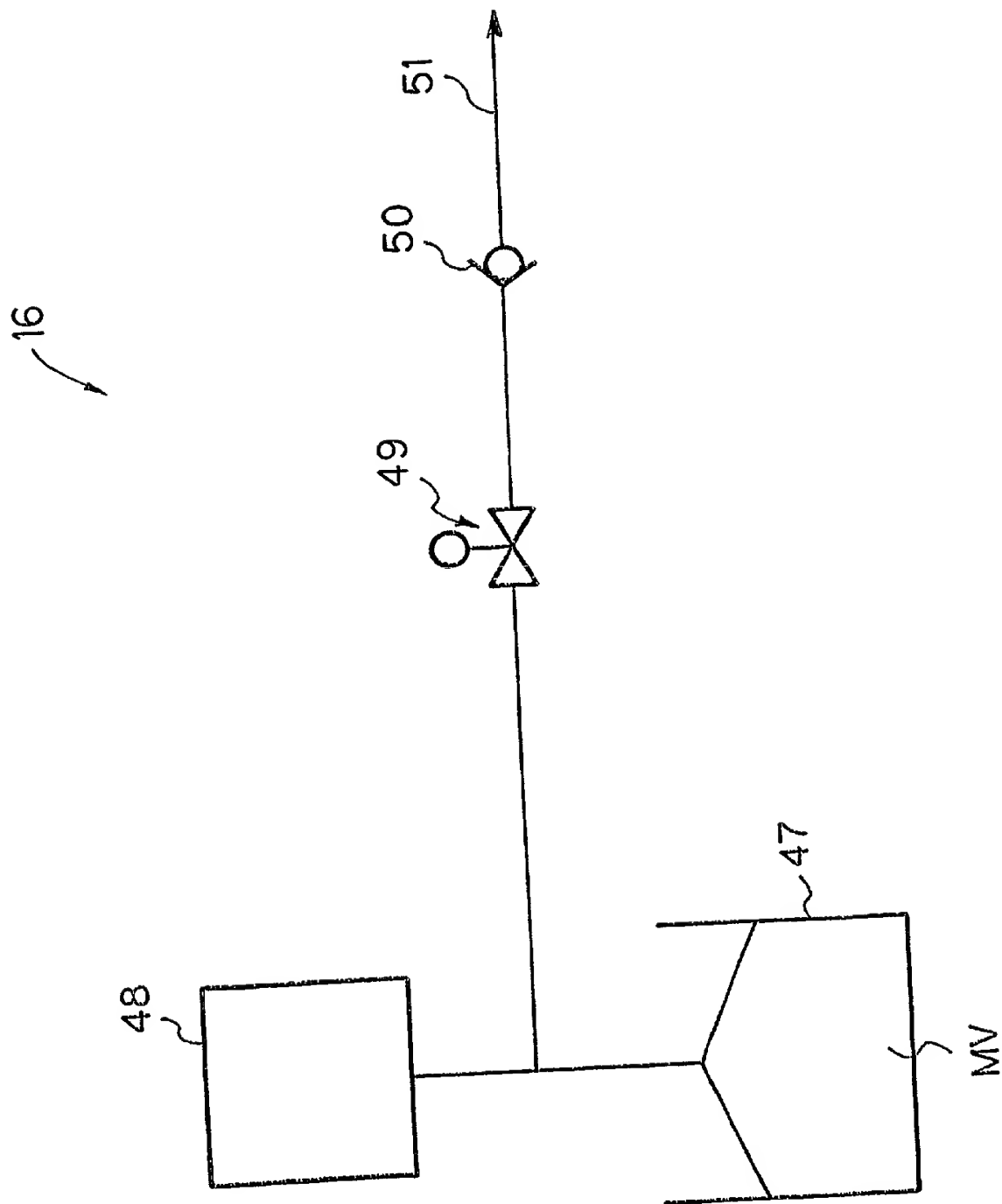


Fig. 6

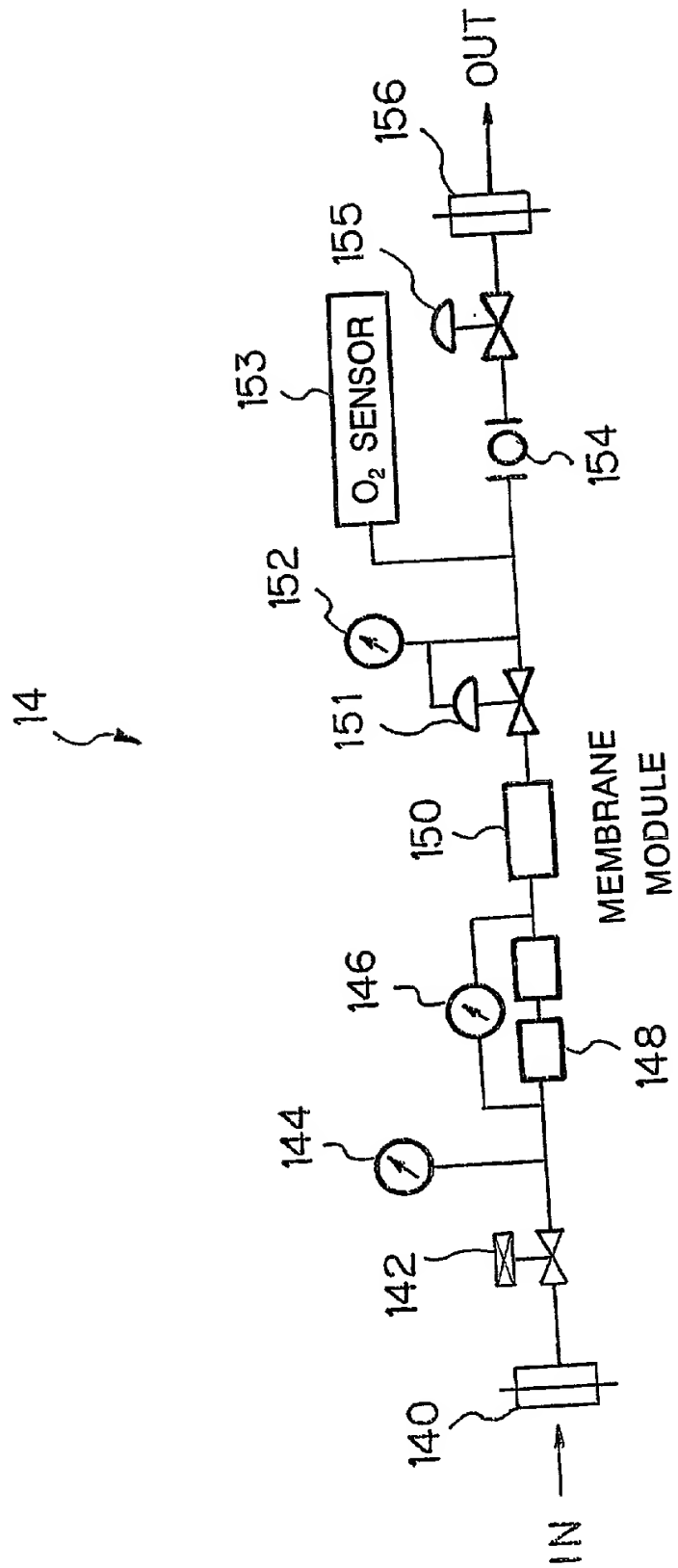
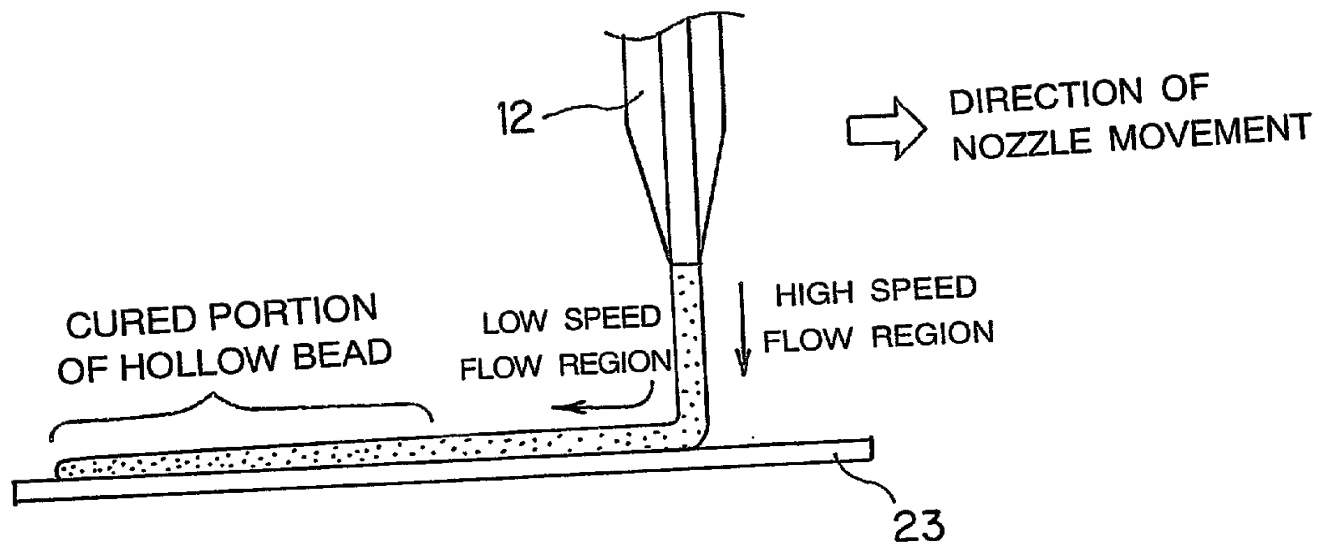


Fig. 7

(a)



(b)

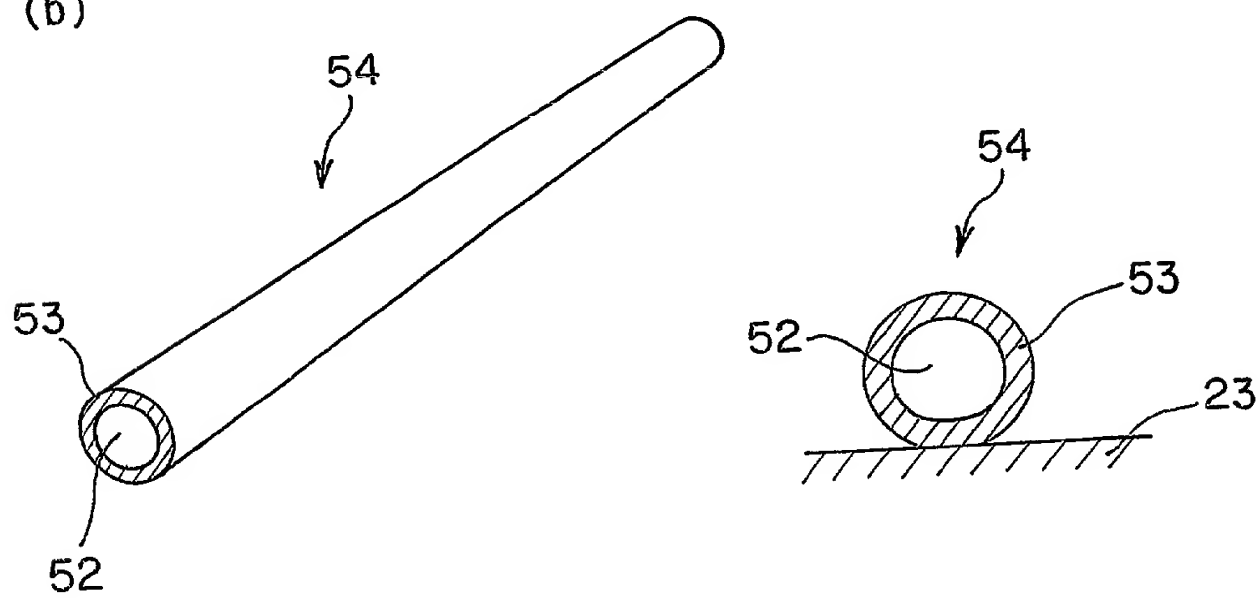
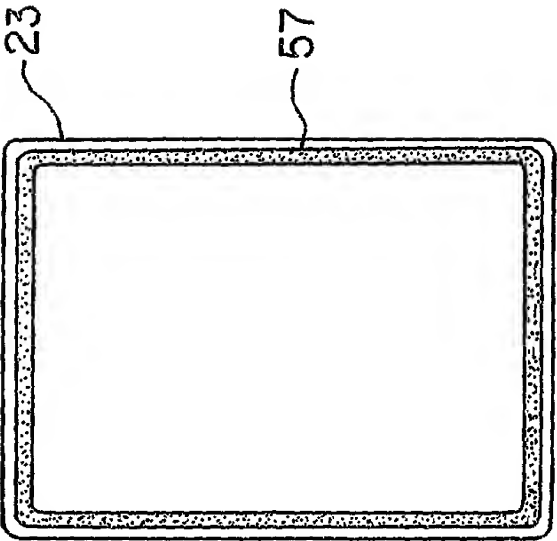


Fig. 8

(b) AFTER APPLYING



(a) BEFORE APPLYING

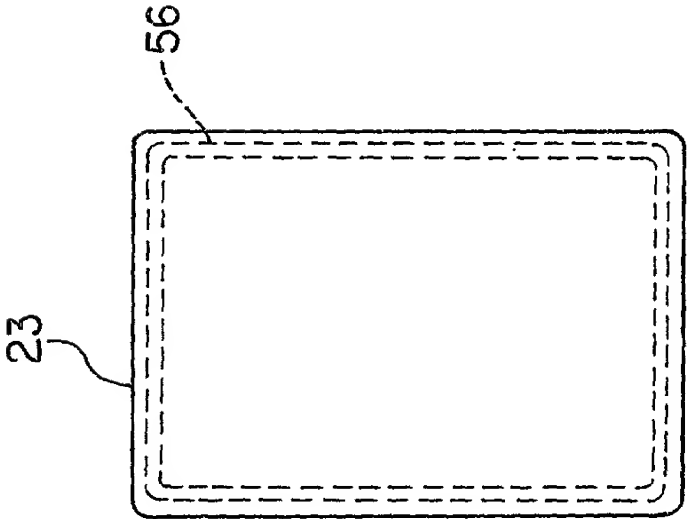
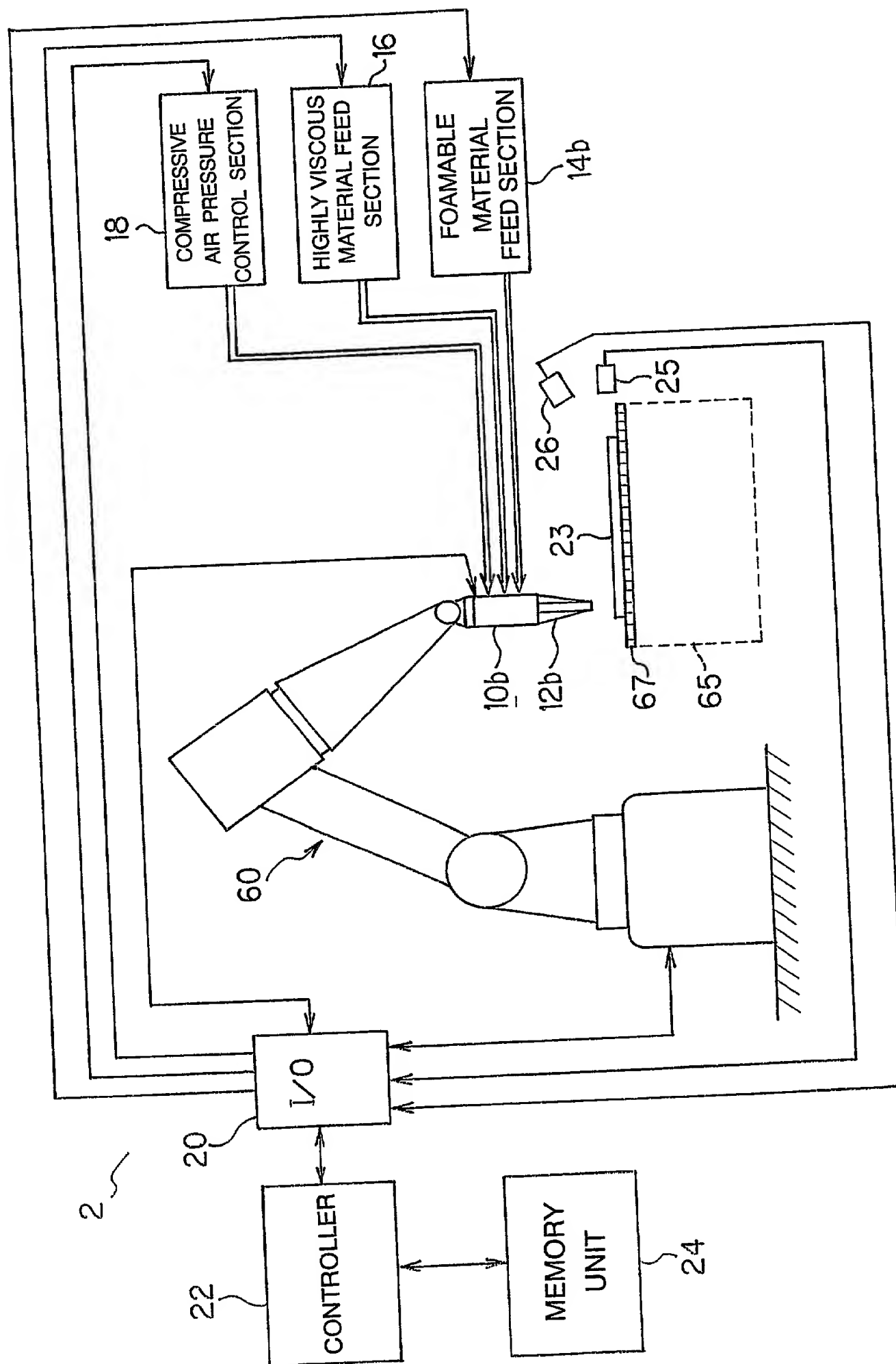


Fig. 9



**Fig. 10**

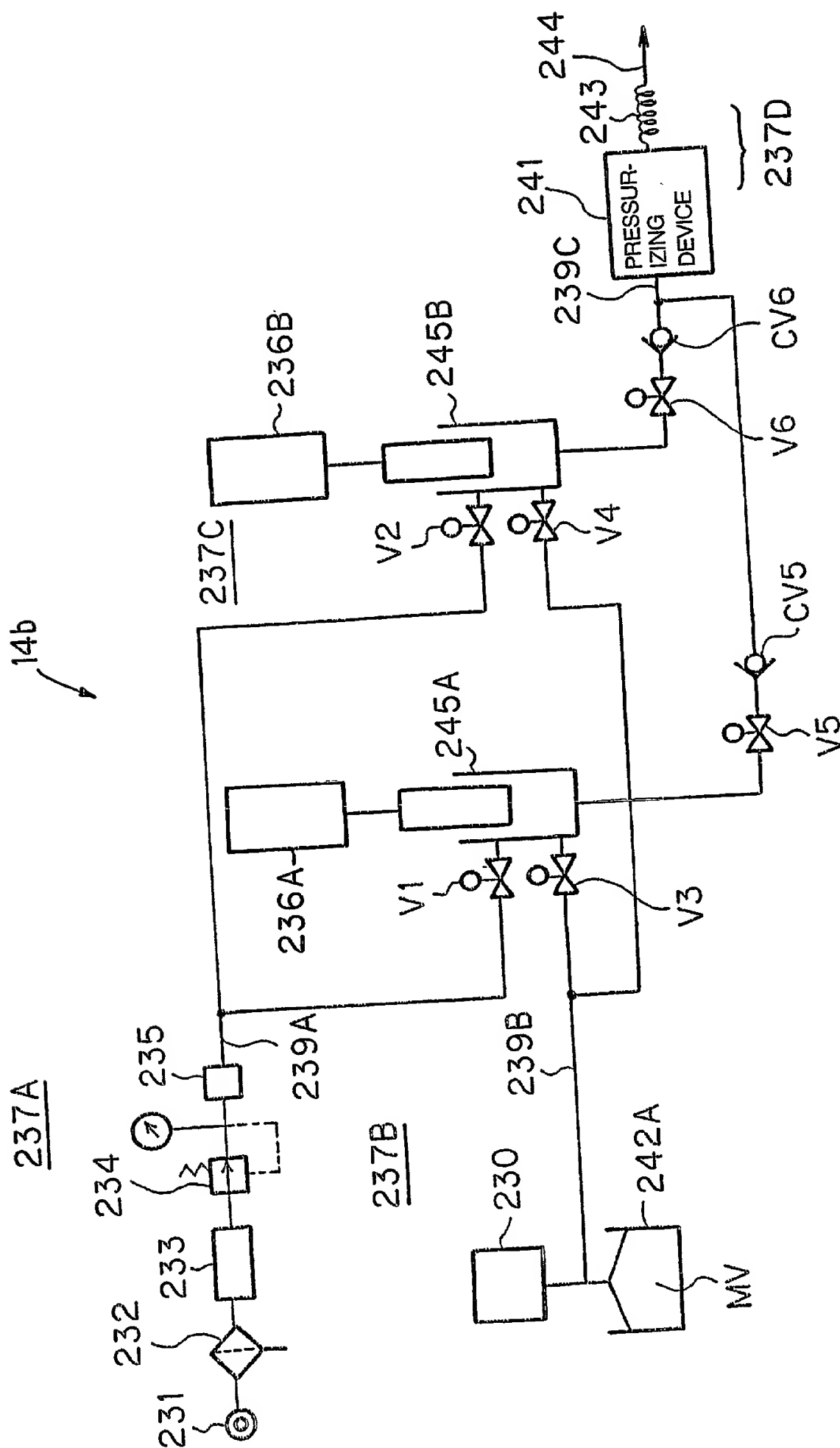
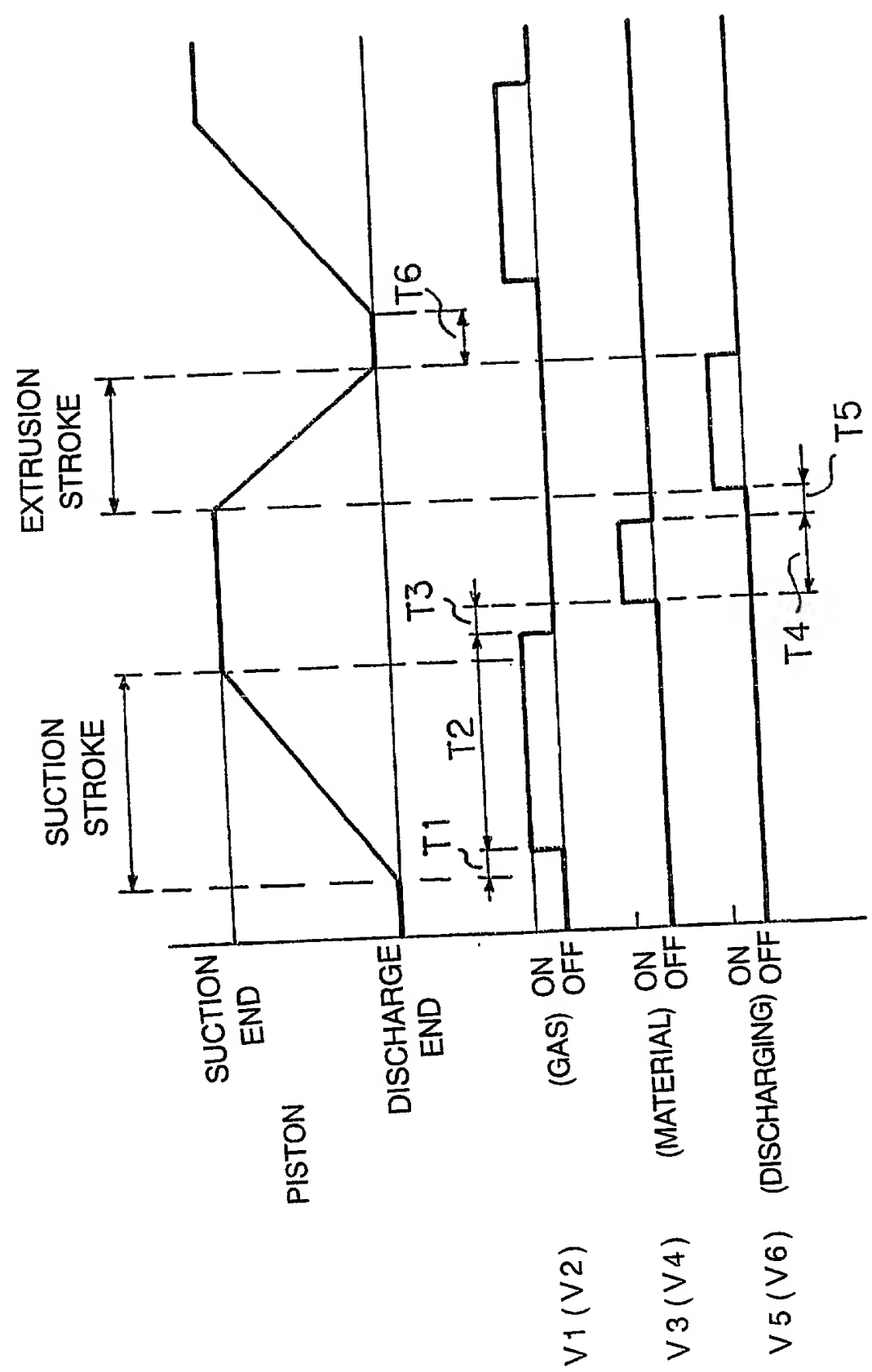
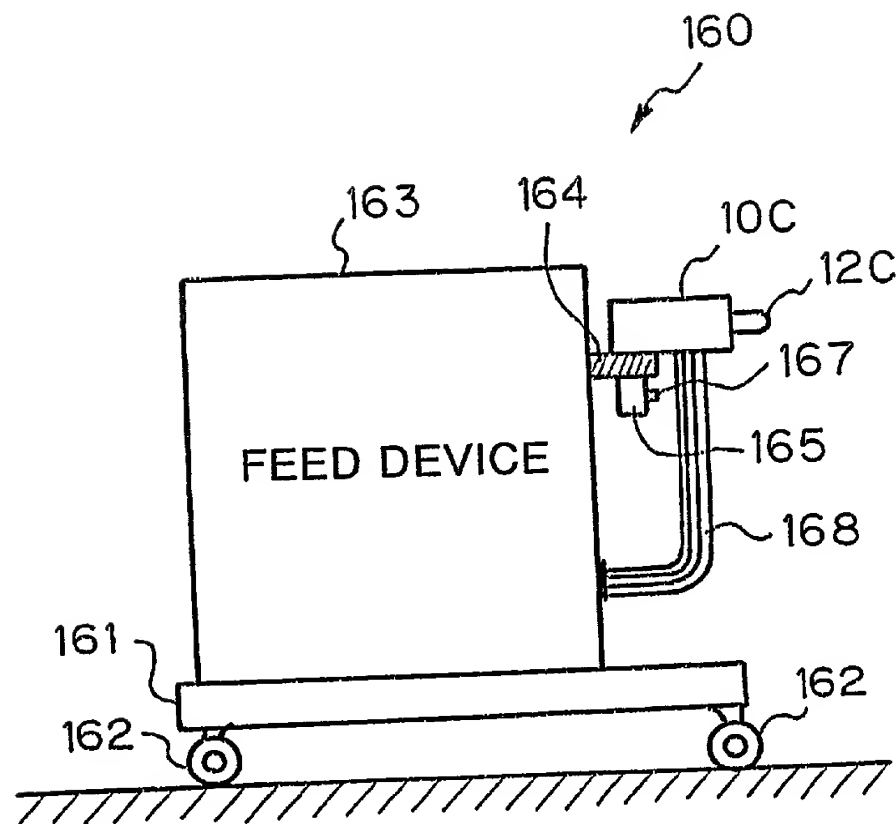
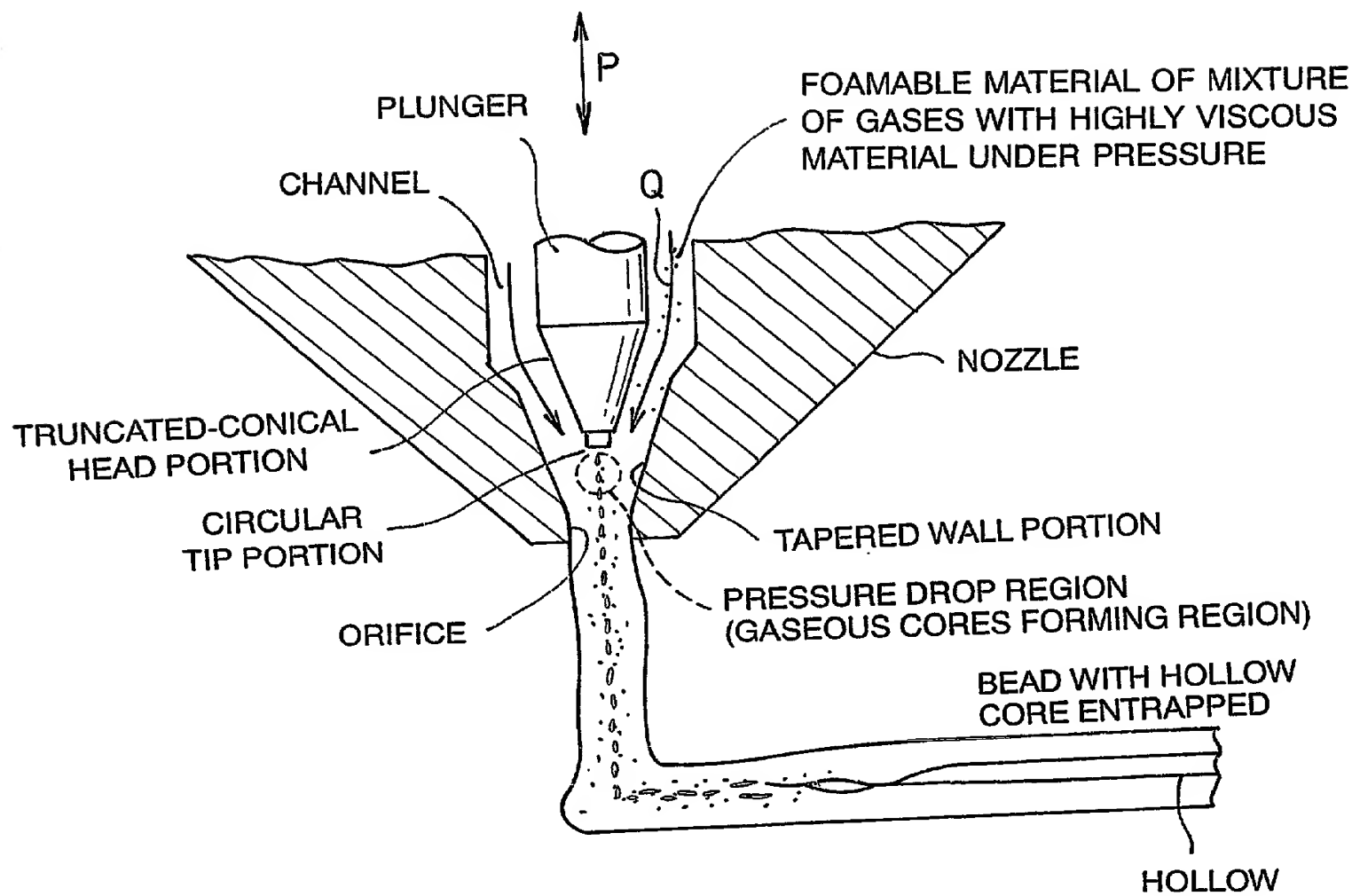


Fig. 11



*Fig. 12*



*Fig. 13*

**DECLARATION AND POWER OF ATTORNEY FOR U.S. PATENT APPLICATION**

(X) Original ( ) Supplemental ( ) Substitute ( ) PCT ( ) Design

As a below named inventor, I hereby declare that: my residence, post office address and citizenship are as stated below next to my name; that I verily believe that I am the original, first and sole inventor (if only one name is listed below) or an original, first and joint inventor (if plural inventors are named below) of the subject matter which is claimed and for which a patent is sought on the invention entitled:

Title: METHOD AND APPARATUS FOR MOLDING BEAD

of which is described and claimed in:

( ) the attached specification, or

( ) the specification in the application Serial No. \_\_\_\_\_ filed \_\_\_\_\_;  
and with amendments through \_\_\_\_\_ (if applicable), or

(X) the specification in International Application No. PCT/JP99/06313, filed Nov. 12, 1999, and as amended on \_\_\_\_\_ (if applicable).

I hereby state that I have reviewed and understand the content of the above-identified specification, including the claims, as amended by any amendment(s) referred to above.

I acknowledge my duty to disclose to the Patent and Trademark Office all information known to me to be material to patentability as defined in Title 37, Code of Federal Regulations, §1.56.

I hereby claim priority benefits under Title 35, United States Code, §119 (and §172 if this application is for a Design) of any application(s) for patent or inventor's certificate listed below and have also identified below any application for patent or inventor's certificate having a filing date before that of the application on which priority is claimed:

| COUNTRY | APPLICATION NO. | DATE OF FILING    | PRIORITY CLAIMED |
|---------|-----------------|-------------------|------------------|
| Japan   | 322177/1998     | November 12, 1998 | Yes              |
|         |                 |                   |                  |
|         |                 |                   |                  |
|         |                 |                   |                  |
|         |                 |                   |                  |
|         |                 |                   |                  |

I hereby claim the benefit under Title 35, United States Code, §120 of any United States application(s) listed below and, insofar as the subject matter of each of the claims of this application is not disclosed in the prior United States application in the manner provided by the first paragraph of Title 35, United States Code, §112, I acknowledge the duty to disclose information material to patentability as defined in Title 37, Code of Federal Regulations, §1.56 which occurred between the filing date of the prior application and the national or PCT international filing date of this application.

| APPLICATION SERIAL NO. | U.S. FILING DATE | STATUS: PATENTED, PENDING, ABANDONED |
|------------------------|------------------|--------------------------------------|
|                        |                  |                                      |
|                        |                  |                                      |
|                        |                  |                                      |

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And I hereby appoint John T. Miller, Reg. No. 21,120; Michael R. Davis, Reg. No. 25,134; Matthew M. Jacob, Reg. No. 25,154; Jeffrey Nolton, Reg. No. 25,408; Warren M. Cheek, Jr., Reg. No. 33,367; Nils E. Pedersen, Reg. No. 33,145 and Charles R. Watts, Reg. No. 33,142, who together constitute the firm of WENDEROTH, LIND & PONACK, L.L.P., attorneys to prosecute this application and to transact all business in the U.S. Patent and Trademark Office connected therewith.

I hereby authorize the U.S. attorneys named herein to accept and follow instructions from YUASA AND HARA as to any action to be taken in the U.S. Patent and Trademark Office regarding this application without direct communication between the U.S. attorneys and myself. In the event of a change in the persons from whom instructions may be taken, the U.S. attorneys named herein will be so notified by me.

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|------------------------------------|--------------------|-------------------------|---|
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|                                      |                    |                         |   |
|--------------------------------------|--------------------|-------------------------|---|
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| <b>Residence &amp; Citizenship</b>   | <b>CITY</b>        | <b>STATE OR COUNTRY</b> | <b>COUNTRY OF CITIZENSHIP</b>           |
| <b>Post Office Address</b>           | <b>ADDRESS</b>     | <b>CITY</b>             | <b>STATE OR COUNTRY</b> <b>ZIP CODE</b> |

I further declare that all statements made herein of my own knowledge are true, and that all statements on information and belief are believed to be true; and further that these statements were made with the knowledge that willful false statements and the like so made are punishable by fine or imprisonment, or both, under Section 1001 of Title 18 of the United States Code, and that such willful false statements may jeopardize the validity of the application or any patent issuing thereon.

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5th Inventor \_\_\_\_\_ Date \_\_\_\_\_

6th Inventor \_\_\_\_\_ Date \_\_\_\_\_

7th Inventor \_\_\_\_\_ Date \_\_\_\_\_

The above application may be more particularly identified as follows:

U.S. Application Serial No. \_\_\_\_\_ Filing Date \_\_\_\_\_

Applicant Reference Number \_\_\_\_\_ Atty Docket No. \_\_\_\_\_

Title of Invention \_\_\_\_\_